

Description and Application

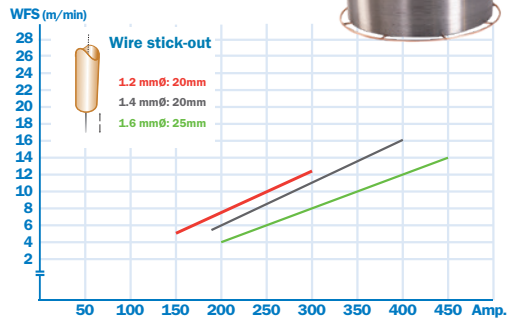
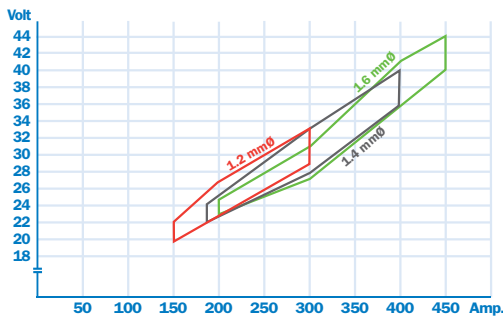
This rutile flux cored wire is very versatile due to its excellent welding characteristics. It is an all positional wire with negligible spatter loss, easy slag removal, soft stable arc, excellent bead profile and appearance, resulting in superb welder appeal.

DW-A50 is used for butt or fillet welding of mild and Y.S.: 420MPa steels.

Due to its good mechanical properties combined with less than 5ml/100g hydrogen content in all weld metal (according to EN ISO), this wire is very well suited for constructional steel work, ship building, bridge construction, tank building, etc.



Recommended Parameter Range, for flat position



Typical Chemical Analysis (wt. %)

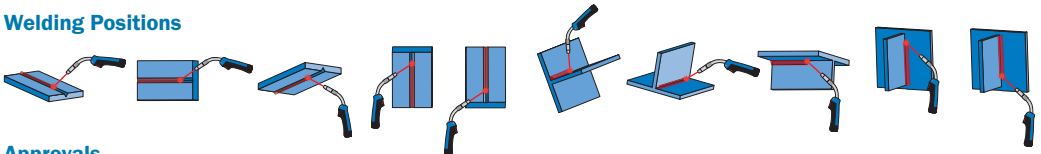
C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.48	1.22	0.013	0.009	-	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-20°C
Guaranty	510	570	30	110
	min.420	500~640	min.20	min.47

Example of Diffusible hydrogen content: 4.3 [ml/100g]

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
3YS H5	III YMS H5	SA3YM H5	3SA,3YSA H5	3Y40MS H5	TÜV, DB, RINA