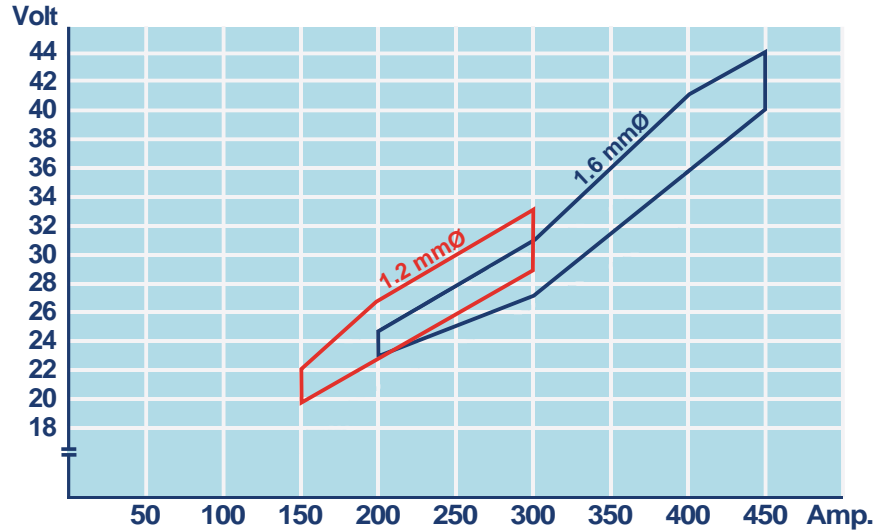


Description and Application

DW-55S is a rutile flux cored wire. It can be operated with great ease and it achieves good mechanical properties. DW-55S is used primarily for welding 460 N/mm² class yield strength steels. This wire is well suited for constructional steel work, ship building, bridge construction, tank building. etc.

Recommended Parameter Range, for flat position



Note: The above parameter ranges are intended for Ar+CO₂. More voltage is necessary for 100% CO₂.

Chemical Analysis (wt.%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Shielding gas
DW-55S	0.05	0.70	1.34	0.008	0.009	-	-	-	100%CO ₂
	0.05	0.83	1.53	0.008	0.009	-	-	-	80%Ar-20%CO ₂

Mechanical Properties

	R _e (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	CV (J) -20°C	CV (J) -30°C	Shielding gas
DW-55S	540	607	29	107	80	100%CO ₂
	584	638	28	92	86	80%Ar-20%CO ₂

Welding Positions

DW-55S
1.2, 1.6mm



Approvals

	LR	DNV	BV	GL	ABS	R.M.R.S.	Others
DW-55S	3Y42	-	-	-	-	-	TÜV, DB