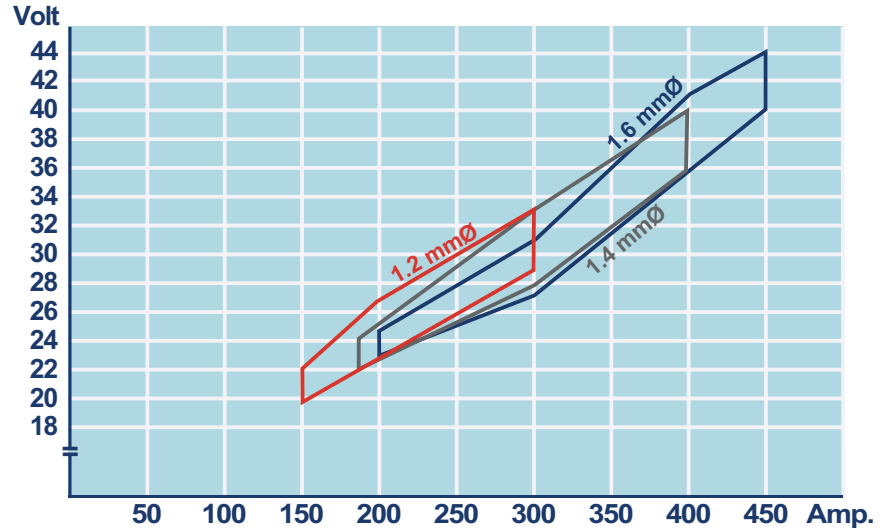


Description and Application

These are both rutile flux cored wires and are very versatile due to their excellent welding characteristics. They are all positional wires with negligible spatter loss, easy slag removal, soft stable arcs, excellent bead profile and appearance, resulting in superb welder appeal.

DW-50 and DW-A50 are used for butt or fillet welding of mild and 490 N/mm² high tensile strength steels. Due to their good mechanical properties, these wires are 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-50	0.04	0.67	1.29	0.011	0.008	-	-	-	100%CO ₂
DW-A50	0.05	0.48	1.22	0.013	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-50	510	582	31	108	68	100%CO ₂
DW-A50	510	570	30	110	-	80%Ar-20%CO ₂

Welding Positions

DW-50
1.2, 1.6mm



DW-A50
1.2, 1.4, 1.6mm



Approvals

	LR	DNV	BV	GL	ABS	R.M.R.S.	Others
DW-50	3S,3YS	IIIYMS	SA3YM	3YS	3SA,3YSA	3Y40MS	-
DW-A50	3S,3YS	IIIYMS	SA3YM	3YS	3SA,3YSA	3Y40MS	TÜV,DB