TRUSTARC™ DW-55L

100%CO_2
EN ISO 17632-A-T 46 6 1.5Ni P C 1 H5
AWS A5.29 E81T1-K2C

DW-A55L

80%Ar - 20%CO_2
EN ISO 17632-A-T 46 6 1.5Ni P M 1 H5
AWS A5.29 E81T1-K2M

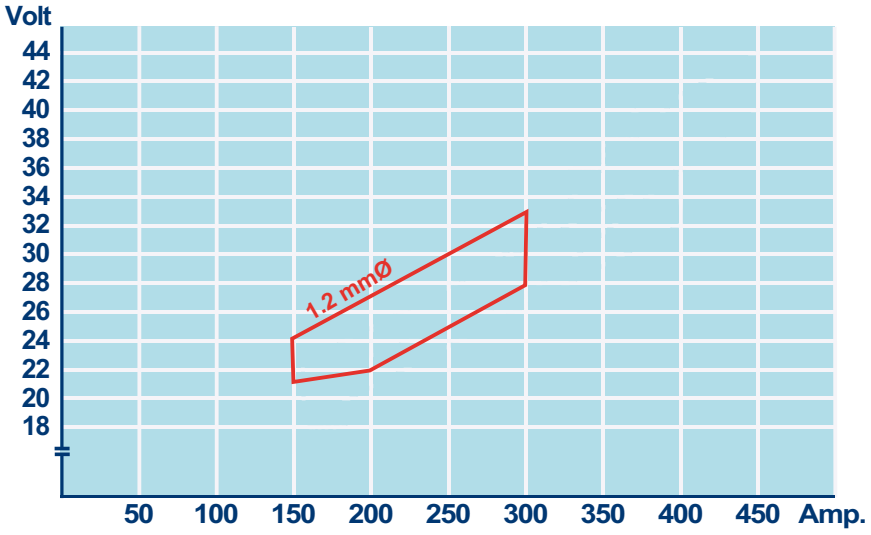
Description and Application

Both DW-55L & DW-A55L are rutile flux cored wires which have been specially formulated to meet the rigorous demands for low temperature service as found in the offshore, shipbuilding and chemical industries.

These wires with excellent weld metal toughness down to -60°C still exhibit superb welding characteristics such as a very smooth, but forceful, stable arcs producing little spatter and a fast freezing self releasing slag.

These wires are widely applied to the welding of thin to heavy section carbon steels.

Recommended Parameter Range, for flat position



Note: The above parameter ranges are intended for Ar+CO_2. More voltage is necessary for 100% CO_2.

Chemical Analysis (wt.%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Shielding gas
DW-55L	0.04	0.38	1.32	0.010	0.008	1.40	-	-	100%CO_2
DW-A55L	0.06	0.30	1.15	0.009	0.007	1.41	-	-	80%Ar-20%CO_2

Mechanical Properties

	R_e (N/mm^2)	R_m(N/mm^2)	A_5 (%)	CV (J) -40°C	CV (J) -60°C	Shielding gas
DW-55L	550	620	27	110	70	100%CO_2
DW-A55L	558	626	27	123	94	80%Ar-20%CO_2

Welding Positions

DW-55L
1.2mm

DW-A55L
1.2mm

Approvals

	LR	DNV	BV	GL	ABS	R.M.R.S.	Others
DW-55L	5Y40S	V YMS NV2-4,4-4	SA3YMHH, MG	6Y40H15S	3SA,4Y400SA, MG	-	NK.KR.CCS
DW-A55L	5Y46S	V Y46MS NV2-4,4-4	-	-	3SA,3YSA, MG	-	-