

100%CO<sub>2</sub>  
EN ISO 17632-A-T 46 6 1.5Ni P C 1 H5  
AWS A5.29 E81T1-K2C

80%Ar - 20%CO<sub>2</sub>  
EN ISO 17632-A-T 46 6 Z P M 1 H5  
AWS A5.29 E81T1-Ni1M

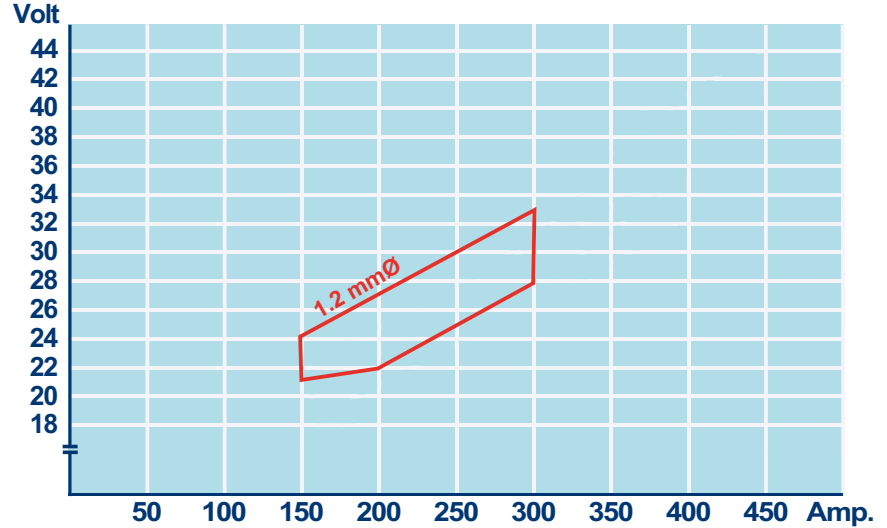
### Description and Application

DW-55LSR and DW-A55LSR are rutile flux cored wires whose weld metals tolerate post weld heat treatment (PWHT) without an adverse degradation of mechanical properties.

DW-A55LSR produces a nominal 0.9%Ni weld metal which means that it fulfils NACE requirements for oil and gas production equipment in sourgas service.

These properties make for a varied range of usages in pipeline construction and offshore applications.

### Recommended Parameter Range, for flat position



Note: The above parameter ranges are intended for Ar+CO<sub>2</sub>. More voltage is necessary for 100% CO<sub>2</sub>.

### Chemical Analysis (wt.%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Shielding gas
DW-55LSR	0.06	0.26	1.15	0.008	0.007	1.51	-	-	100%CO <sub>2</sub>
DW-A55LSR	0.05	0.33	1.32	0.009	0.008	0.90	-	-	80%Ar-20%CO <sub>2</sub>

### Mechanical Properties

	R <sub>e</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	CV (J) -46°C	CV (J) -60°C	Shielding gas
DW-55LSR	480	565	33	-	115	100%CO <sub>2</sub>
620°C x 1 hr (SR)	440	530	34	-	100	100%CO <sub>2</sub>
DW-A55LSR	510	570	29	137	120	80%Ar-20%CO <sub>2</sub>
620°C x 2 hrs (SR)	450	530	33	132	70	80%Ar-20%CO <sub>2</sub>

### Welding Positions

DW-55LSR

1.2mm



DW-A55LSR

1.2mm



### Approvals

	LR	DNV	BV	GL	ABS	R.M.R.S.	Others
DW-55LSR	5Y42S, 5Y42srS, MG	V Y42MS, MG NV2-4L,4-4L	SA4Y40M HH, MG	-	5YQ420SA 4Y400SA	-	NK
DW-A55LSR	5Y42S	V Y42MS NV2-4L,4-4L	-	-	5YQ420SA	-	NK