

100%CO<sub>2</sub>  
 EN ISO 17632-A-T 50 6 Z P C 2 H5  
 AWS A5.29 E91T1-Ni2C-J

80%Ar - 20%CO<sub>2</sub>  
 EN ISO 17632-A-T 50 6 Z P M 2 H5  
 AWS A5.29 E91T1-GM

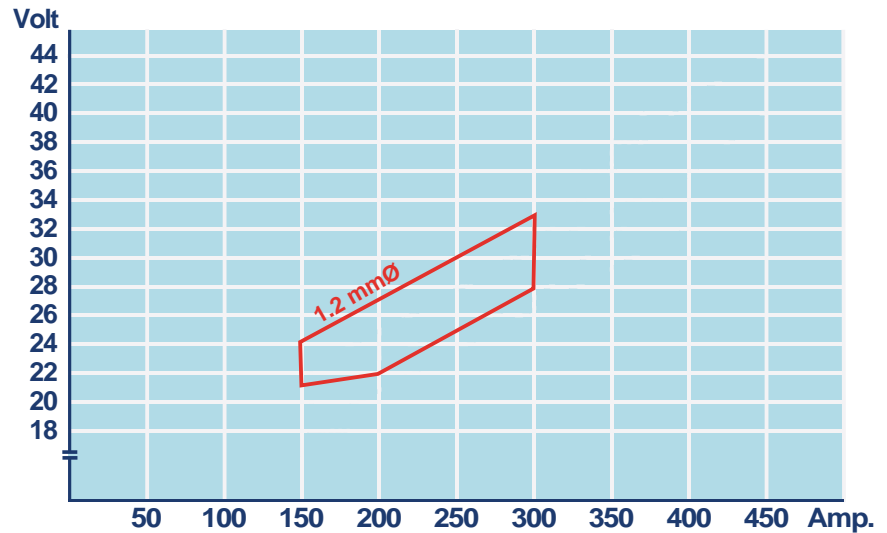
### Description and Application

DW-62L and DW-A62L are new rutile flux cored wires which have been specially formulated to meet the rigorous demands for 500N/mm<sup>2</sup> yield strength class low temperature service steels, as found in the offshore shipbuilding and chemical industries.

Not only do both wires have excellent CTOD values at the standard -10°C test temperature, but they also have excellent CTOD values at the very severe test temperature of -40°C.

These wires are applied to the welding of medium to heavy section butt or fillet weld joints.

### 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-62L	0.08	0.27	1.32	0.009	0.007	2.6	-	-	100%CO <sub>2</sub>
DW-A62L	0.07	0.32	1.33	0.007	0.011	2.1	-	-	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) -40°C	CV (J) -60°C	Shielding gas
DW-62L	601	660	25	109	100	100%CO <sub>2</sub>
DW-A62L	561	641	27	105	82	80%Ar-20%CO <sub>2</sub>

### Welding Positions

DW-62L  
1.2mm



DW-A62L  
1.2mm



### Approvals

	LR	DNV	BV	GL	ABS	R.M.R.S.	Others
DW-62L	-	-	-	-	5YQ500	5Y50 MS	-
DW-A62L	-	-	-	-	-	-	-