

80%Ar - 20%CO<sub>2</sub>

EN ISO 18276-A-T 69 4 Z P M 2 H5

AWS A5.29 E111T1-GM

80%Ar - 20%CO<sub>2</sub>

EN ISO 18276-A-T 69 6 Mn2.5Ni M M 3 H5

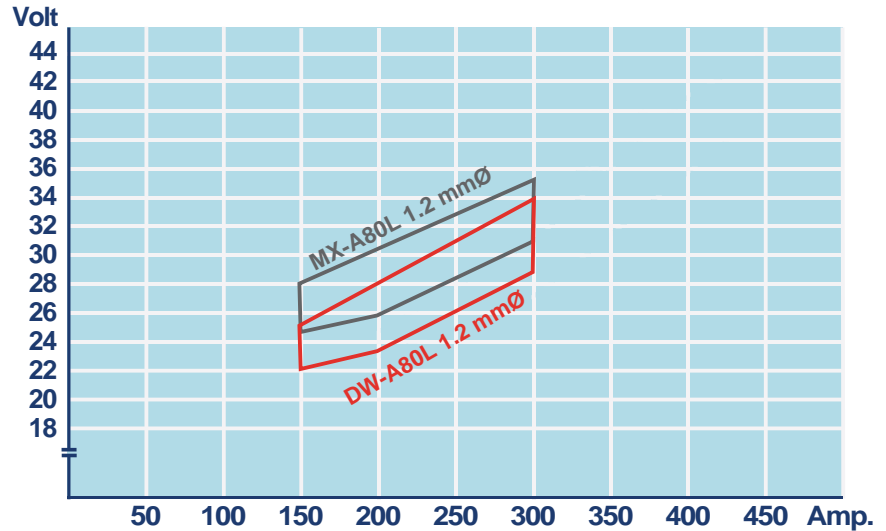
AWS A5.28 E110C-G

## Description and Application

DW-A80L and MX-A80L are designed for welding 690 N/mm<sup>2</sup> yield strength steels that are used in heavy industries such as offshore, pipeline, crane, construction machinery, etc.

DW-A80L is a rutile flux cored wire for all positional welding. MX-A80L is a metal cored wire for flat and horizontal welding. These wires provide excellent mechanical properties and crack resistance.

## Recommended Parameter Range, for flat position



## Chemical Analysis (wt.%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Shielding gas
DW-A80L	0.07	0.31	1.86	0.007	0.006	2.49	-	0.16	80%Ar-20%CO <sub>2</sub>
MX-A80L	0.06	0.48	1.87	0.008	0.010	2.37	-	0.09	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-A80L	764	813	21	90	-	80%Ar-20%CO <sub>2</sub>
MX-A80L	720	791	24	145	121	80%Ar-20%CO <sub>2</sub>

## Welding Positions

DW-A80L  
1.2mm



MX-A80L  
1.2mm



## Approvals

	LR	DNV	BV	GL	ABS	R.M.R.S.	Others
DW-A80L	-	-	-	-	-	-	-
MX-A80L	-	-	-	-	-	-	-