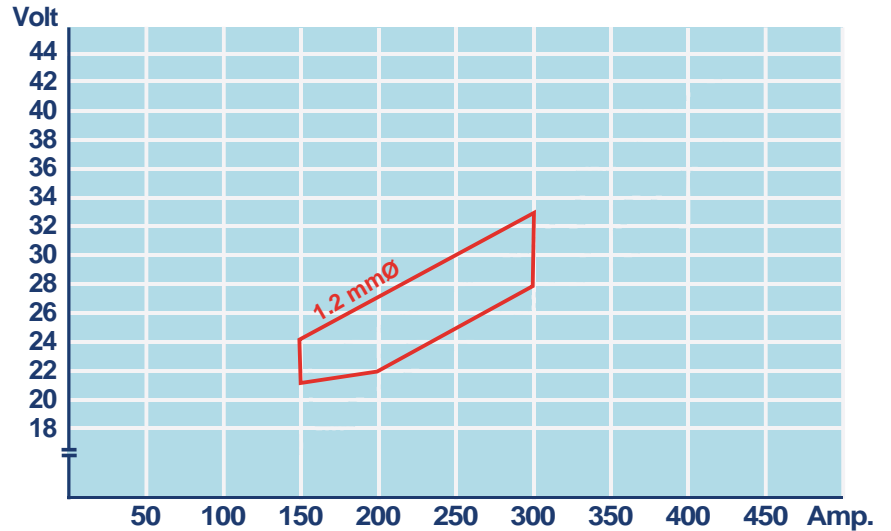


Description and Application

DW-A65L is a new rutile flux cored wire which has been specially formulated to meet the rigorous demands for 640N/mm² class high tensile strength steel for low temperature service as found in the offshore shipbuilding and chemical industries. This wire is applied to the welding of medium to heavy section butt or fillet weld joints.

Recommended Parameter Range, for flat position



Chemical Analysis (wt.%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Shielding gas
DW-A65L	0.05	0.35	1.17	0.010	0.009	1.69	-	0.11	80%Ar-20%CO ₂

Mechanical Properties

	R _e (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	CV (J) -40°C	Shielding gas
DW-A65L	601	660	24	82	80%Ar-20%CO ₂

Welding Positions

DW-A65L
1.2mm



Approvals

	LR	DNV	BV	GL	ABS	R.M.R.S.	Others
DW-A65L	-	-	-	-	-	-	-