

## Flux Cored Arc Welding

**DW-100**
**FAMILIARC**

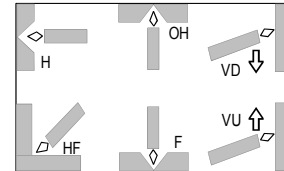
Rutile type flux cored wire for mild steel and 490MPa high tensile strength steel

**Classification:** ASME / AWS A5.20 E71T-1C  
 EN 758 T 42 0 P C 1 H10  
 JIS Z3313 YFW-C50DR

**Features:**

- Suitable for butt and fillet welding in all positions including vertical downward
- Soft and stable arc, less fume and spattering, smooth bead appearance, and good slag removal

**Shielding gas:** CO<sub>2</sub>
**Polarity:** DC-EP

**Welding positions:**

**Chemical composition of all-weld metal (%) as per AWS**

	C	Si	Mn	P	S
Example	0.05	0.45	1.35	0.013	0.009
Guaranty	≤0.12	≤0.90	≤1.75	≤0.03	≤0.03

**Mechanical properties of all-weld metal as per AWS**

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	510	570	30	-18°C: 85
Guaranty	≥400	≥490	≥22	-18°C ≥27

**Recommended welding parameters**

	1.2mm	1.4mm	1.6mm
Dia.	1.2mm	1.4mm	1.6mm
F	120~300A	150~400A	180~450A
HF	120~300A	150~350A	180~400A
H	120~280A	150~320A	180~350A
VU, OH	120~260A	150~270A	180~280A
VD	200~300A	220~300A	250~300A

**Approvals**

AB	LR	NV	BV	NK	Others
2SA, 2Y400SA(H10)	2S,2YS(H10) 2M,2YM(H10)	II YMS(H10)	SA2M HH, SA2YM HH	KSW52Y40G (C)H10	GL, CCS, CR, KR

**Packages**

Dia. (mm)	Type	Weight (kg)	Dia. (mm)	Type	Weight (kg)	Dia. (mm)	Type	Weight
1.2	Spool	12.5	1.4	Spool	12.5	1.6	Spool	12.5
	Spool	15		Spool	15		Spool	20
	Spool	20		Spool	20		Pack	350
	Pack	250		Pack	250			
				Pack	350			