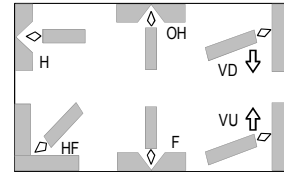


Flux Cored Arc Welding

DW-50
FAMILIARC
Rutile type flux cored wire for mild steel and 490MPa high tensile strength steel
Classification: ASME / AWS A5.20 E71T-1C/1M, -9C/9M
 EN 758 T 42 2 P C/M 1 H5

- Features :**
- Suitable for butt and fillet welding in all positions including vertical downward
 - Excellent usability with soft and stable arc, less fume and spattering, good bead appearance and smooth slag removal
 - Applicable for ship class E-grade plates

Welding positions:

Shielding gas: CO₂ or Ar-CO₂ mixture

Polarity: DC-EP

Chemical composition of all-weld metal (%) as per AWS (Shielding gas: CO₂)

	C	Si	Mn	P	S
Example	0.04	0.67	1.29	0.011	0.008
Guaranty	≤0.12	≤0.90	≤1.75	≤0.03	≤0.03

Mechanical properties of all-weld metal as per AWS (Shielding gas: CO₂)

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	510	582	31	-18°C: 108
Guaranty	≥400	≥490	≥22	-18°C ≥27

Recommended welding parameters

	1.2mm	1.6mm
F	120~300A	180~450A
HF	120~300A	180~400A
H	120~280A	180~400A
VU, OH	120~270A	180~280A
VD	200~300A	250~300A

Approvals

AB	LR	NV	NK	Others
3SA,3YSA(H5)	3S,3YS(H5)	III YMS(H5)	KSW53G(C)	GL, CWB

Packages

Dia. (mm)	Type	Weight (kg)	Dia. (mm)	Type	Weight (kg)
1.2	Spool	5	1.6	Spool	15
	Spool	15		Spool	20
	Spool	20		Pack	350
	Pack	250			