

## Flux Cored Arc Welding

**DW-55E**
**FAMILIARC**

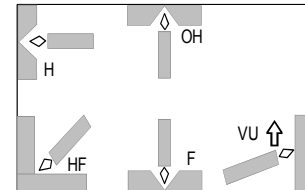
Rutile type flux cored wire for mild steel and 490MPa high tensile strength steel for low temperature service

**Classification:** ASME / AWS A5.20 E71T-9C-J  
 EN 758 T 42 4 P C 1 H5  
 JIS Z3313 YFL-C504R

**Features :** ■ Suitable for butt and fillet welding in all positions  
 ■ Excellent impact value at low temperatures down to -40°C

**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	Ni
Example	0.05	0.40	1.42	0.012	0.010	0.41
Guaranty	≤0.12	≤0.90	≤1.75	≤0.03	≤0.03	≤0.50

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

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	540	590	29	-40°C: 80
Guaranty	≥400	≥480	≥22	-40°C ≥27

**Recommended welding parameters**

	1.2mm	1.4mm
Dia.	1.2mm	1.4mm
F	150~300A	150~400A
HF	150~300A	150~350A
H	150~280A	150~300A
VU, OH	150~250A	150~250A

**Approvals**

AB	LR	NV	BV	NK	Others
3SA, 3Y400SA(H5)	4Y40S(H5)	ⅢYMS(H5)	SA3,SA3YM HHH	KSW54Y40G (C)H5	GL, CR

**Packages**

Dia. (mm)	Type	Weight (kg)	Dia. (mm)	Type	Weight (kg)
1.2	Spool	12.5	1.4	Spool	15
	Spool	15		Spool	20
	Spool	20			