

Flux Cored Arc Welding

DW-55L
FAMILIARC

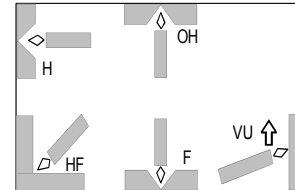
Rutile type flux cored wire for mild steel and 490-550MPa high tensile strength steel for low temperature service

Classification : ASME / AWS A5.29 E81T1-K2C
 EN 758 T46 6 1.5Ni P C 1 H5
 JIS Z3313 YFL-C506R

Features : ■ Suitable for butt and fillet welding in all positions
 ■ Excellent impact value at low temperatures down to -60

Shielding gas : CO₂

Polarity : DC-EP

Welding positions:

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

	C	Si	Mn	P	S	Ni
Example	0.04	0.38	1.32	0.010	0.008	1.40
Guaranty	≤0.15	≤0.80	0.50~ 1.75	≤0.03	≤0.03	1.00~ 2.00

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	550	620	27	-60°C: 70
Guaranty	≥470	550~690	≥22	-60°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,4Y400SA, MG	5Y40S(H15)	VYMS(H10), NV2-4,4-4	SA3YM(HH), MG	KSWL3G(C)	GL, CCS, KR

Packages

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