

## Flux Cored Arc Welding

# DW-55LSR

# FAMILIARC

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

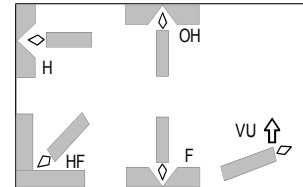
**Classification:** ASME / AWS A5.29 E81T1-K2C  
 EN 758 T46 6 1.5Ni P C 1 H5  
 JIS Z3313 YFL-C506R

**Features :** ■ Suitable for butt and fillet welding in all positions  
 ■ Excellent impact value at low temperatures down to -60°C in the as-welded and PWHT conditions

**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	0.06	0.26	1.15	0.008	0.007	1.51
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)	PWHT (°C×h)
Example	480	565	33	-60°C: 115	AW
	440	530	34	-60°C: 100	620X1
Guaranty	≥470	550~690	≥22	-60°C≥27	AW

### Recommended welding parameters

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

### Approvals

AB	LR	NV	BV	NK
5YQ420SA(H5) 4Y400SA(H5)	5Y42S, 5Y42srS(H10), MG	VY42MS(H10), MG NV2-4L, 4-4L	SA4Y40M HH, MG	KSW5Y42G(C)H10, MG

### Packages

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