

Flux Cored Wire for 460MPa Yield Strength Steel

FAMILIARC™ DW-55S

KOBELCO

TECHNICAL FLASH

NEW

FAMILIARC™ DW-55S

100%CO₂/80%Ar - 20%CO₂
EN ISO 17632-A-T 46 2 P C/M 1 H5
AWS A5.20 E71T-1C/1M,-9C/9M

VERSATILE

CONSTANT

COMFORTABLE

REMARKABLE

BENEFICIAL

Features of the FAMILIARC™ DW-55S

Our newly developed FAMILIARC™ DW-55S for 460MPa yield strength steel is now available from one of our professional welding distributors close to you. FAMILIARC™ DW-55S is an all position gas shielded rutile flux cored wire with excellent weldability.

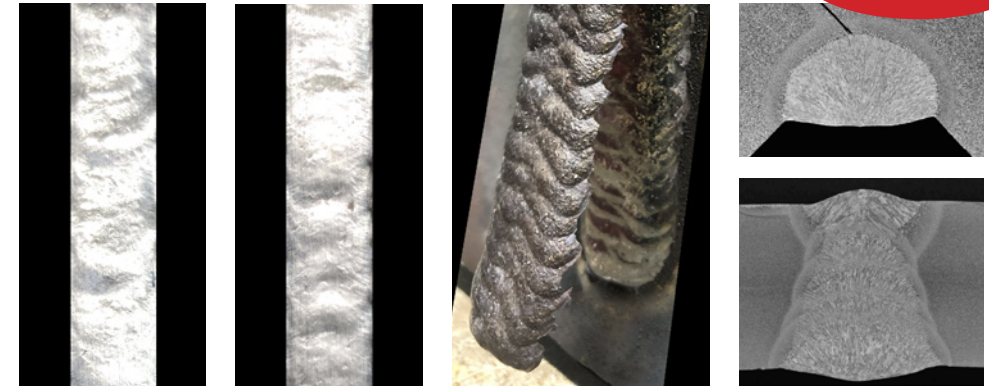
FAMILIARC™ DW-55S is designed for both shielding gas C1 and M21. FAMILIARC™ DW-55S arc stability and the slag removability are excellent when you use both C1 and M21. FAMILIARC™ DW-55S has a wider applicable welding condition to achieve flat welding bead appearance for vertical up position.

If you still haven't tested our FAMILIARC™ DW-55S, it is time to see for yourself what a KOBELCO welding consumables can do for you in your application. KOBELCO can provide consistent high quality from batch to batch, achieved when flux cored wire is manufactured under strict control.

As the leading expert and manufacturer in flux cored wires, KOBELCO have the products and solutions, for you and the challenges you are facing daily. Implement KOBELCO products in your welding applications, and see for yourself how the world-renowned KOBELCO quality flux cored wire can improve your productivity, your quality, and finally your profit.

If you have any further questions don't hesitate to contact us at marketing@kobelcowelding.nl

Excellent Weldability of FAMILIARC™ DW-55S



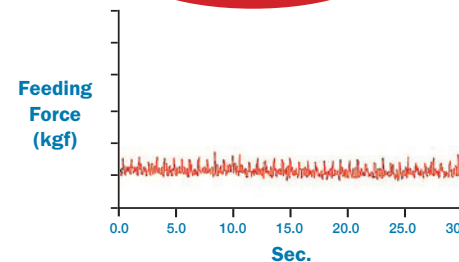
Vertical-Up Fillet (PF)
Left; C1, Right; M21

Vertical-Up Position (PF)
Slag Removability

Vertical-Up Position (PF)
Macrostructure

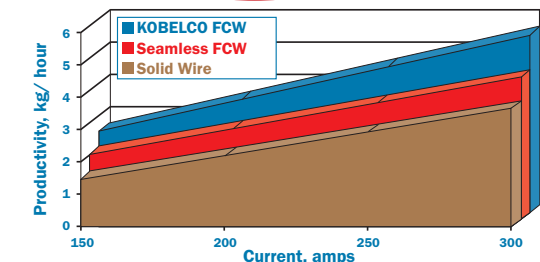
FLAT & SMOOTH

CONSTANT QUALITY



Wire Feedability
6m Torch Testing

PRODUCTIVITY



Productivity

Typical All Weld Metal Properties

Typical Chemical Analysis (wt. %)

Shielding gas	C	Si	Mn	P	S	Ni	Cr	Mo
100%CO ₂	0.05	0.70	1.34	0.008	0.009	-	-	-
80%Ar-20%CO ₂	0.05	0.83	1.53	0.008	0.009	-	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-20°C	CV(J)-30°C
100%CO ₂	540	607	29	107	80
80%Ar-20%CO ₂	584	638	28	92	86
Guaranty	min.460	530~670	min.20	min.47	-