

DW-55E

100%CO EN ISO 17632-A-T 42 4 P C 1 H5 AWS A5.20 E71T-9C-J EN ISO 9606-1: FM1 EN ISO 4063: 136

Description and Application

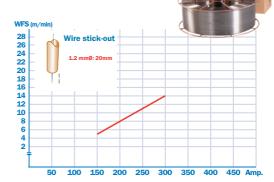
DW-55E is a rutile flux cored wire that has been specially formulated to meet rigorous demands for low temperature service steels. It is applied particularly where really good thoughness is required down to -40°C.

The fast freezing slag promotes easy and very productive positional welding with slag removing easily to reveal a weld bead of smooth appearance. KOBELCO

This wire is used for butt or fillet welding of medium to heavy section carbon steels and is used widely in the shipbuilding and bridge construction industries.

Recommended Parameter Range, for flat position





Typical Chemical Analysis (wt. %)

C	Si	Mn	Р	S	Ni	Cr	Мо
0.05	0.40	1.42	0.012	0.010	0.41	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-40°C
	540	590	29	80
Guaranty	min.420	500~640	min.20	min.47





Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
4Y40S H5	IV Y40MS H5	SA4Y40M H5	4Y400SA H5	-	NK, CR