

Description and Application

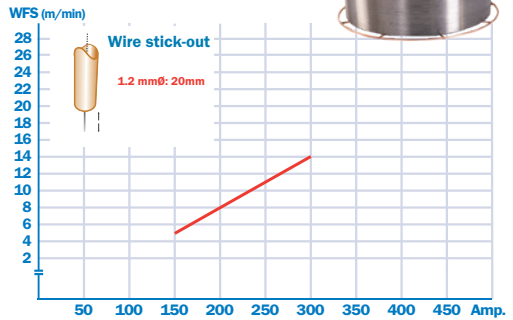
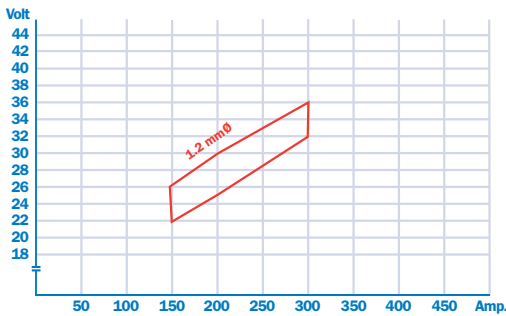
DW-55E is a rutile flux cored wire that has been specially formulated to meet rigorous demands for low temperature service steels. It is applied particularly where really good toughness is required down to -40°C.

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

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. %)

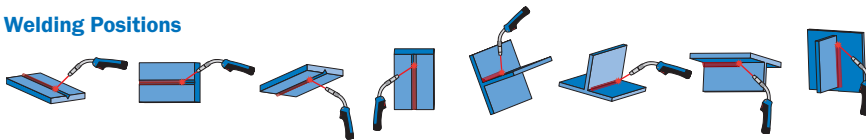
C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.40	1.42	0.012	0.010	0.41	-	-

Typical Mechanical Properties

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

Example of Diffusible hydrogen content: 4.1 [ml/100g]

Welding Positions



Approvals

LR	DNV	BV	ABS	R.M.R.S	Others
4Y40S H5	IVY40MS H5	SA4Y40M H5	4Y400SA H5	-	NK, CR