

## Description and Application

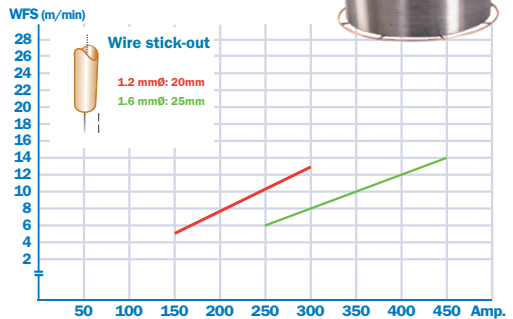
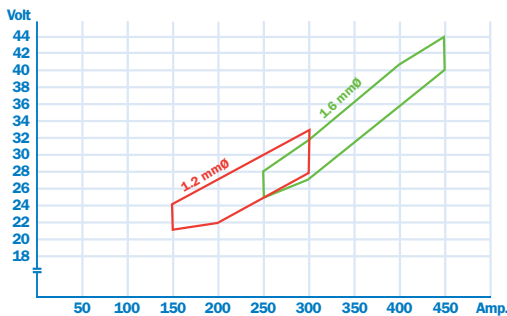
**DW-A55E** is a rutile flux cored wire that was specially formulated to meet rigorous demands for low temperature service steels. This wire is applied particularly where really good toughness is required down to -40°C.

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 the 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. %)

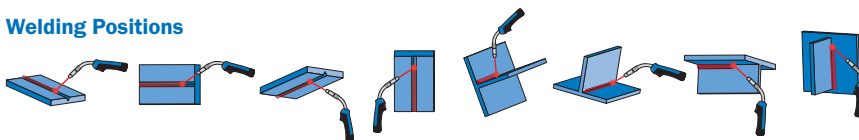
C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.54	1.31	0.013	0.009	0.34	-	-

### Typical Mechanical Properties

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)-40°C
Guaranty	min.460	530~680	min.20	min.47

Example of Diffusible hydrogen content: 4.3 [ml/100g]

### Welding Positions



### Approvals

LR	DNV	BV	ABS	R.M.R.S	Others
4Y40S H5	IVYMS H5	SA4Y40M HHH	4Y400SA H5	4Y40MS H5	TÜV, DB, RINA, CE