

Description and Application

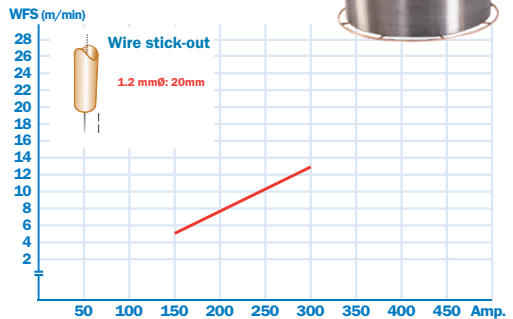
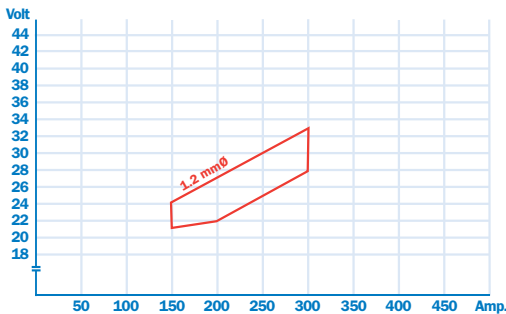
DW-A55ESR is a rutile flux cored wire that was specially formulated to meet rigorous demands for low temperature service applications requiring really good toughness down to -40°C after post weld heat treatment.

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 and fillet welding of medium to heavy section carbon steels and is used widely in the Offshore and Pressure vessel construction industries.



Recommended Parameter Range, for flat position



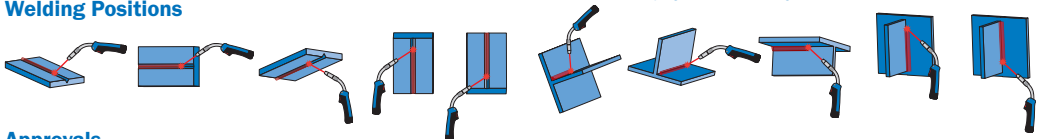
Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Ni	Cr	Mo
0.06	0.57	1.50	0.009	0.006	0.45	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-40°C
As welded	521	606	32	132
620°Cx3hrs(SR)	502	585	33	96
Guaranty (As welded)*	min.420	500~640	min.20	min.47

Welding Positions



Example of Diffusible hydrogen content: 3.9 [ml/100g]

Approvals

LR	DNV	BV	ABS	R.M.R.S	Others
-	-	-	4Y400SA H5	-	TUV, CE

*Contact us for the Guaranty value for specific SR conditions.