

Description and Application

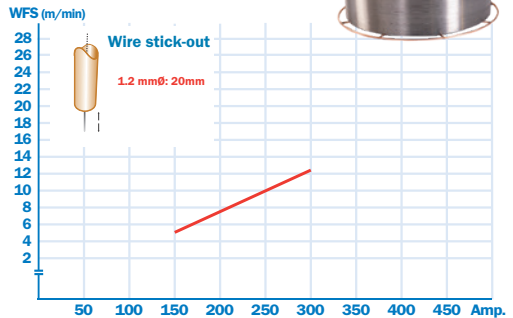
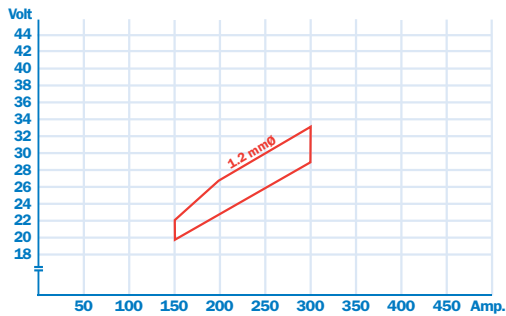
DW-A55S is a rutile type flux cored wire with negligible spatter loss, easy slag removal, soft arc, excellent bead profile and appearance.

DW-A55S is suited for butt or fillet welding of Y.S.: 460MPa steels.

Due to its good mechanical properties combined with less than 5ml/ 100g hydrogen content in all weld metal (according to EN ISO), this wire is very well suited for constructional steel, bridge construction, tank building, etc.



Recommended Parameter Range, for flat position



Typical Chemical Analysis (wt. %)

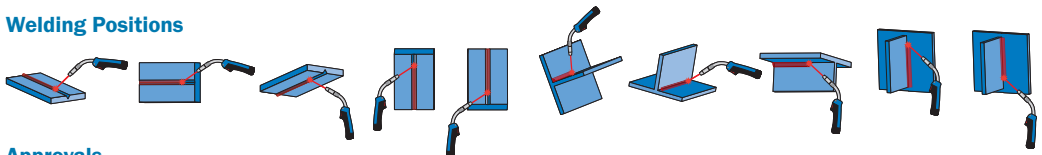
C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.51	1.28	0.010	0.009	-	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-20°C	CV(J)-30°C
Guaranty	535	600	26	120	100
	min.460	530~670	min.22	-	min.47

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

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	IIY42MS H5	-	-	-	RINA, CE