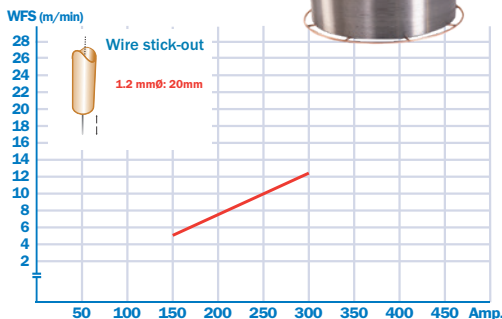
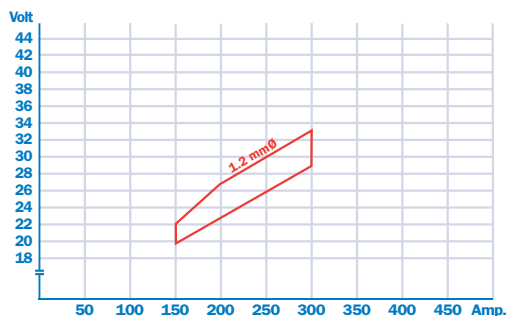


## Description and Application

**DW-55S** is a rutile flux cored wire. It can be operated with great ease and it achieves good mechanical properties. **DW-55S** is used primarily for welding 460MPa class yield strength steels. This wire is well suited for constructional steel work, ship building, bridge construction, tank building, etc.



### Recommended Parameter Range, for flat position



\* The above values and parameters are for all weld metal produced using 100%CO<sub>2</sub> shielding gas

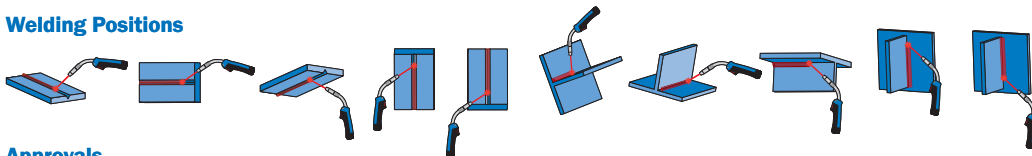
### Typical Chemical Analysis (wt. %)

Shielding gas	C	Si	Mn	P	S	Ni	Cr	Mo
100%CO <sub>2</sub>	0.05	0.70	1.34	0.008	0.009	-	-	-
80%Ar-20%CO <sub>2</sub>	0.05	0.83	1.53	0.008	0.009	-	-	-

### Typical Mechanical Properties

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)-20°C	CV(J)-30°C
100%CO <sub>2</sub>	540	607	29	107	80
80%Ar-20%CO <sub>2</sub>	584	638	28	92	86
Guaranty	min.460	530-670	min.20	min.47	-

### Welding Positions



### Approvals

LR	DNV	BV	ABS	R.M.R.S	Others
-	III Y 42MS (H5)	-	-	-	TÜV, RINA