

Description and Application

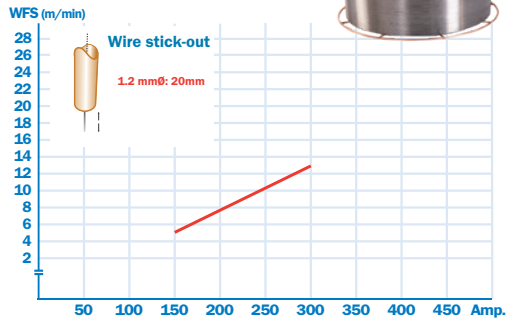
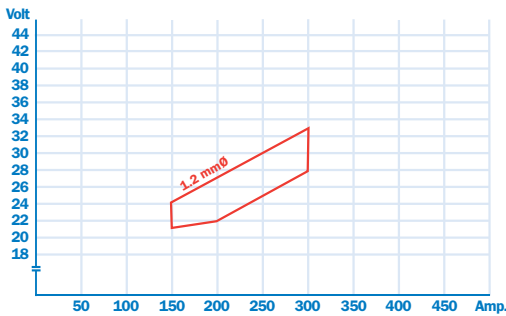
DW-A55EH is a rutile flux cored wire that was specially formulated to meet rigorous demands for low temperature service application required really good toughness down to -40°C. This wire also can be used for applications where post weld heat treatment is required depending on the conditions and toughness requirements.

This wire is very versatile due to its excellent welding characteristics. It is an all positional wire with negligible spatter loss, easy slag removal, soft arc, excellent bead profile and appearance, resulting in superb welder appeal.

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



Recommended Parameter Range, for flat position



Typical Chemical Analysis (wt. %)

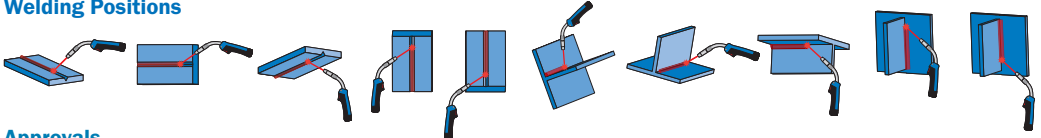
C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.63	1.17	0.010	0.007	0.38	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-40°C
As welded	561	603	29	133
620°Cx3hrs(SR)	485	579	32	119
Guaranty (As welded)	min.420	500-640	min.20	min.47

Example of Diffusible hydrogen content: 4.5 (ml/100g)

Welding Positions



Approvals

LR	DNV	BV	ABS	R.M.R.S	Others
-	-	-	-	-	CE