

Description and Application

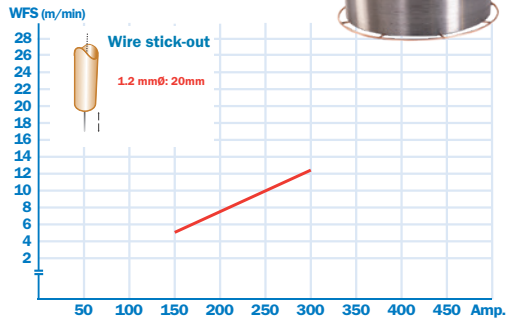
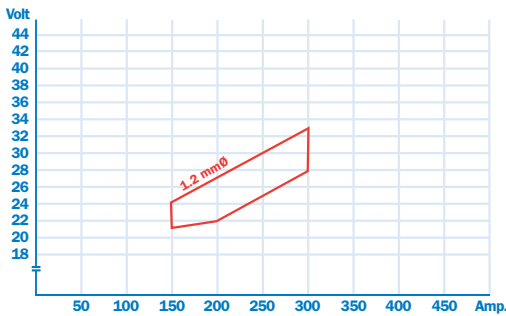
DW-A55LSR is a rutile flux cored wire whose weld metal tolerates post weld heat treatment (PWHT) without an adverse degradation of mechanical properties.

DW-A55LSR produces a nominal 0.9%Ni weld metal which means that it fulfills NACE requirements for oil and gas production equipment in sour gas service.

These properties make for a varied range of usages in pipeline construction and offshore applications.



Recommended Parameter Range, for flat position



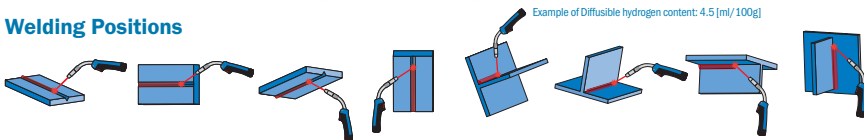
Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.33	1.32	0.009	0.008	0.90	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-60°C
As welded	510	570	29	120
620°C x 2 hr (SR)	450	530	33	70
Guaranty (as welded)	min.460	530-680	min.20	min.47

Welding Positions



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

Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
5Y42S H5	VY42MS H5 NV2-4L,4-4L	SA5Y42 H5	5YQ420SA H5	5Y42MS H5	P.R.S., CE