

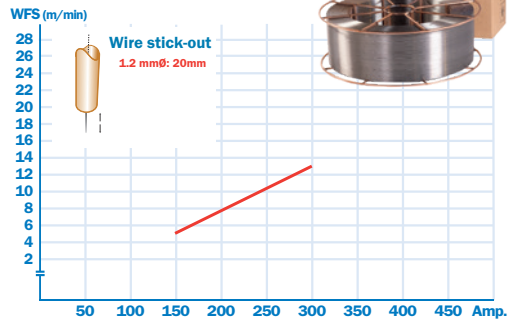
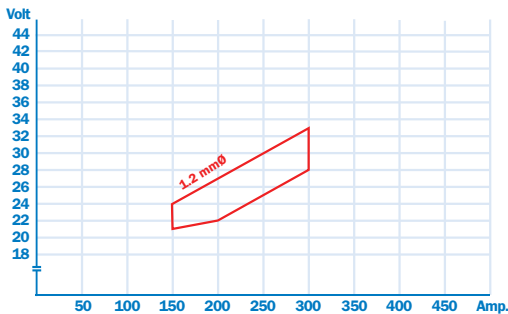
Description and Application

DW-A61LSR is a rutile flux cored wire that was specially formulated to meet the demands for matching S500 structural steel and P500 PV-steel. It has good toughness down to -46°C after post weld heat treatment and fulfils Sour Service / NACE-requirement of Ni < 1,0% in weld metal.

The fast freezing slag promotes easy and very productive positional welding with slag removing easily to reveal a weld bead of smooth appearance. Typical applications are offshore constructions including S500-grades, often combined with S420- and S460-grades.

The tensile properties of **DW-A61LSR** make it applicable for the welding of L450 / X65 and L485 / X70-pipes, including overmatching yield strength.

Recommended Parameter Range, for flat position



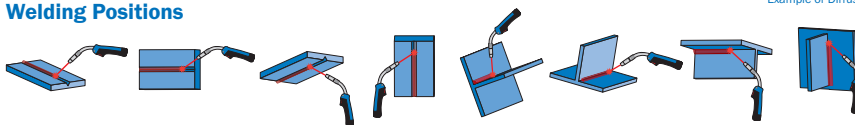
Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.16	1.31	0.006	0.006	0.92	-	0.29

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-40°C	CV(J)-46°C	CV(J)-50°C
As Welded	575	641	25	104	93	87
620°Cx2hrs(SR)	586	649	24	92	71	-
620°Cx4hrs(SR)	588	657	25	88	78	-
Guarantee (As welded)	min.540	620~720	min.18	-	-	min.47

Welding Positions



Example of Diffusible hydrogen content: 2.2 [ml/100g]

Approvals

LR	DNV	BV	ABS	R.M.R.S	Others
4Y50S H5	IVY50MS H5	-	-	-	CE