

TRUSTARC™ DW-A70L

80%Ar - 20%CO₂

EN ISO 18276-A-T 62 5 Mn1NiMo P M 2 H5

AWS A5.29 E101T1-GM

Description and Application

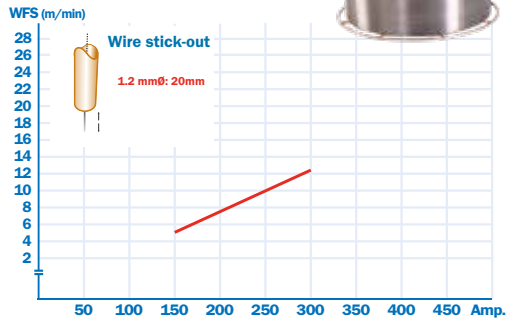
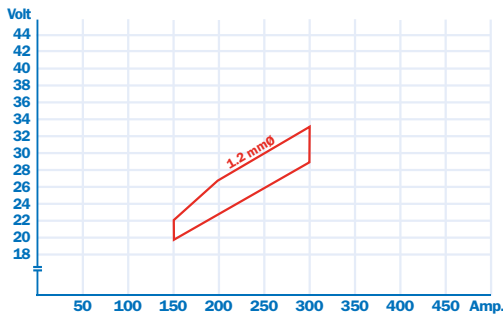
DW-A70L is especially designed to meet the increasing demands in On-Shore and Off-Shore pipelines with the introduction of high strength steels such as X70 and X80, including matching, and/or, requirements for overmatching the nominal yield levels of these materials.

DW-A70L produces a weld metal containing max 1.0%Ni, something that also makes DW-A70L comply with the NACE requirements for sour gas service, making this product very versatile for pipeline application operating on both "sweet" and "sour" conditions.

DW-A70L is a fully rutile flux cored wire, ensuring good operability and weldability on fixed pipes in vertical up PH (5G) position. The wire is designed for manual and fully automated welding processes currently applied by pipeline contractors.



Recommended Parameter Range, for flat position



Typical Chemical Analysis (wt. %)

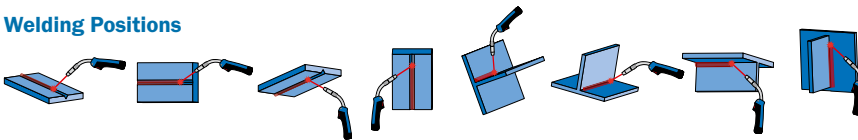
C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.36	1.90	0.008	0.011	0.97	-	0.46

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-50°C
	663	739	21	72
Guarantee	min.620	700~890	min.18	min.47

Example of Diffusible hydrogen content: 3.7 [ml/100g]

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
4Y62S H5	IV Y62MS H5	-	-	-	NAKS