

TRUSTARC™ DW-A65L

80%Ar - 20%CO₂

EN ISO 18276-A-T 55 4 ZMn1,5Ni P M21 2 H5

AWS A5.29 E91T1-K2M-J

EN ISO 9606-1: FM2

EN ISO 4063: 136

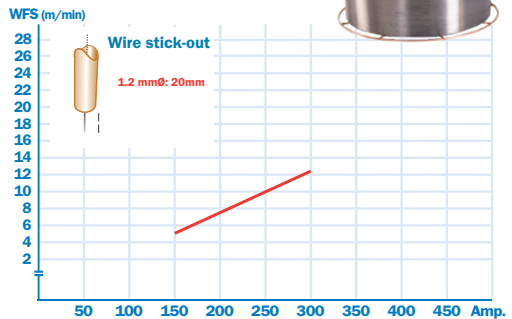
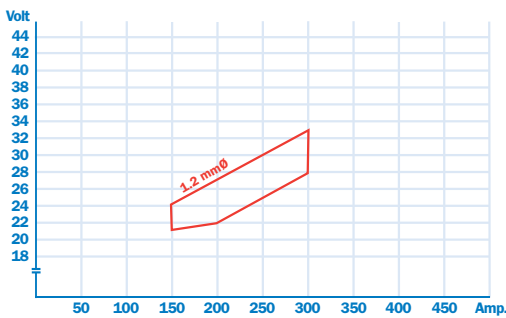
Description and Application

DW-A65L is a rutile flux cored wire specially formulated to meet the rigorous demands for 640 MPa tensile strength class low temperature service steels, as found in the offshore shipbuilding and chemical industries. This wire is applied to the welding of medium to heavy section butt or fillet weld joints.

DW-A65L continues to find new applications due to the increasing use of 550 MPa yield strength low temperature service steels.



Recommended Parameter Range, for flat position



Typical Chemical Analysis (wt. %)

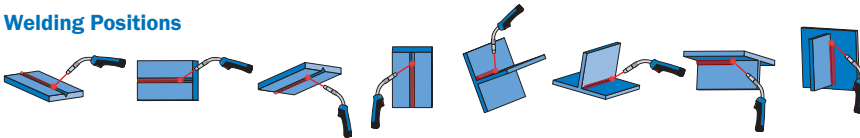
C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.35	1.17	0.010	0.009	1.69	-	0.11

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-40°C
	601	660	24	82
Guaranty	min.550	640~820	min.18	min.47

Example of Diffusible hydrogen content: 4.2 [ml/100g]

Welding Positions



Approvals

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