

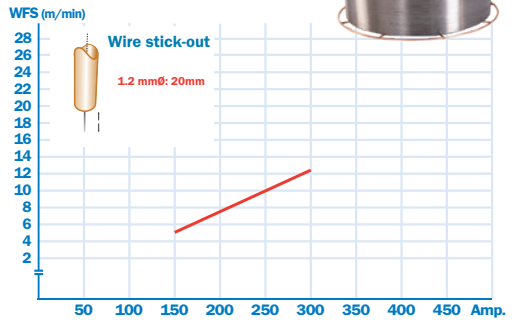
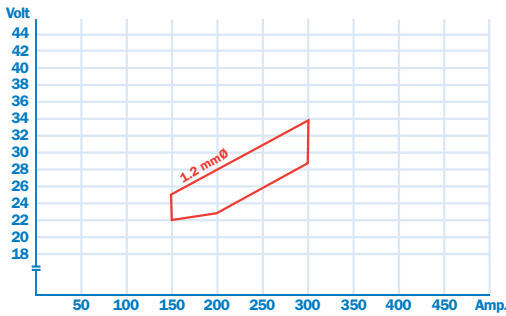
Description and Application

DW-A80L is designed for welding 690 MPa yield strength steels that are used in heavy industries such as offshore, pipeline, crane, construction machinery, etc.

DW-A80L is a rutile flux cored wire for all positional welding. This wire provides excellent mechanical properties and crack resistance.



Recommended Parameter Range, for flat position



Typical Chemical Analysis (wt. %)

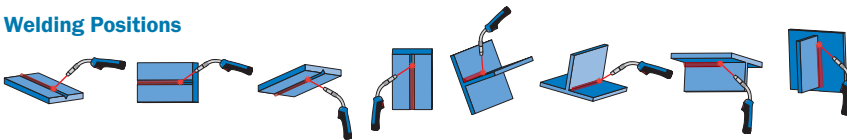
C	Si	Mn	P	S	Ni	Cr	Mo
0.07	0.32	1.82	0.008	0.006	2.42	-	0.15

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-40°C	CV(J)-60°C
Guaranty	739	808	22	94	83
	min.690	770~940	min.17	-	min. 47

Example of Diffusible hydrogen content: 2.4 [ml/100g]

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
4Y69 H5	IV Y69MS H5	-	4YQ690SA H5,MG	-	CE