

# TRUSTARC™ DW-A80L

80%Ar - 20%CO<sub>2</sub>

EN ISO 18276-A-T 69 6 ZMn<sub>2</sub>,5Ni P M21 2 H5

AWS A5.29 E111T1-GM-H4

EN ISO 9606-1: FM2

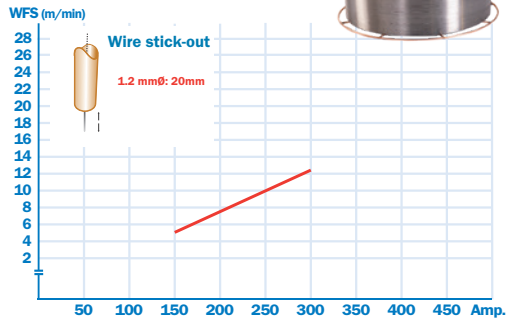
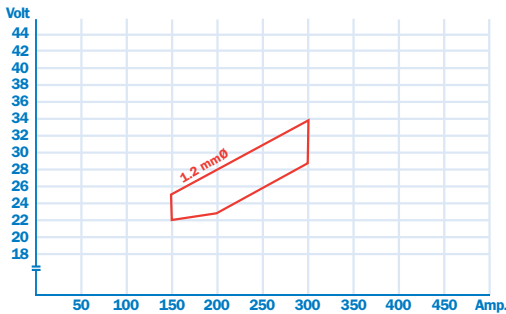
EN ISO 4063: 136

## 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. %)

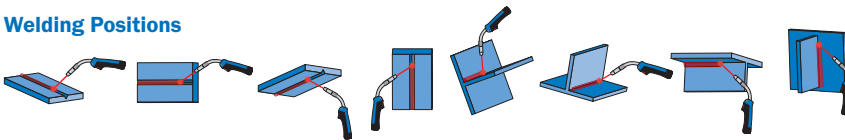
C	Si	Mn	P	S	Ni	Cr	Mo
0.07	0.32	1.82	0.008	0.006	2.42	-	0.15

### Typical Mechanical Properties

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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	BV	ABS	R.M.R.S	Others
4Y69 H5	IV Y69MS H5	-	4YQ690SA H5,MG	-	CE