DW-50LSR TRUSTARC™

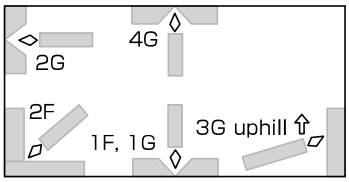
Flux cored wire

Features:
- Excellent impact values down to -60℃ and down to -50℃ in the PWHT condition
- Meets the NACE MR0175 requirements for both chemistry and hardness. The nickel content is normally 1% max.

Classification: AWS A5.29 E71T1-GC

Shielding gas: CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool	
1.2	12.5kg	15kg
Volume mm	300W, 110H, 300L	

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.06	0.12
Si	0.29	1.00
Mn	1.34	0.50~1.75
P	0.009	0.030
S	0.007	0.030
Ni	0.88	0.70~1.00
Cr	0.01	0.15
Mo	0.01	0.35
V	<0.01	0.05

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill, 4G
1.2	150~300	150~280	150~250

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	480	425	400min.
TS (MPa)	560	520	483~655
El on 4d (%)	31	35	20min.
IV -60℃ (J)	110	110	27min.
PWHT (℃xh)	AW	620x1	AW

Approvals

ABS	5Y400SA, H5
LR	5Y40S, H5
DNV	VY40MS (H5)
RS	5Y40SM H5