# DW-50W FAMILIARC™

**Flux cored wire**

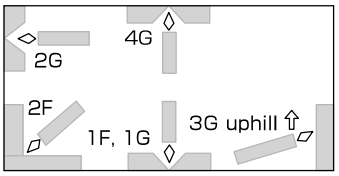
**Features:** ▪ Applicable for weather proof steel

**Classification:** AWS -

**Shielding gas:** $CO_2$

**Polarity:** DCEP

**Welding Positions:**




## Packaging data

| ϕ mm | Spool | | | Drum |
|---|---|---|---|---|
| 1.2 | 12.5kg | 15kg | 20kg | 250 |
| **Volume mm** | 300W, 110H, 300L | | | 530ϕ, 820H |

## Composition (all-weld metal mass%)

| | Typical | Guaranty [a] |
|---|---|---|
| **C** | 0.04 | 0.12 |
| **Si** | 0.49 | 0.90 |
| **Mn** | 1.12 | 0.50~1.60 |
| **P** | 0.010 | 0.030 |
| **S** | 0.008 | 0.030 |
| **Ni** | 0.33 | 0.10~0.45 |
| **Cr** | 0.48 | 0.45~0.75 |
| **Cu** | 0.39 | 0.30~0.75 |

Note: [a] Single values are maximum.

## Welding parameters (A)

| ϕ mm | 1F, 1G, 2F, 2G | 3G uphill, 4G |
|---|---|---|
| 1.2 | 120~280 | 120~260 |

## All-weld mechanical properties

| | Typical | Guaranty |
|---|---|---|
| **0.2%YS (MPa)** | 510 | 400min. |
| **TS (MPa)** | 590 | 490~670 |
| **El on 4d (%)** | 27 | 20min. |
| **IV 0℃ (J)** | 140 | 47min. |