DW-55E FAMILIARC™

Flux cored wire

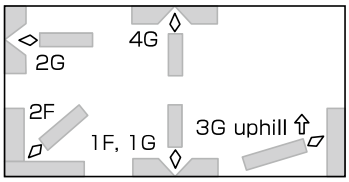
Features: ▪ Excellent impact values down to -40℃

Classification: AWS A5.20 E71T-9C-J

Shielding gas: CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool		
1.2	12.5kg	15kg	20kg
1.4	-	15kg	-
Volume mm	300W, 110H, 300L		

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.05	0.12
Si	0.38	0.90
Mn	1.42	1.75
P	0.01	0.03
S	0.01	0.03
Ni	0.35	0.50
Cr	0.03	0.20
Mo	0.01	0.30
V	0.02	0.08
Cu	0.02	0.35

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	540	400min.
TS (MPa)	590	483~655
El on 4d (%)	29	22min.
IV -40℃ (J)	80	27min.

Approvals

ABS	4Y400SA, H5
LR	4Y40S, H5
DNV	ⅣYMS (H5)
BV	SA4YM H5
NK	KSW54Y40G (C) H5
CR	3YS-HH, L1YS-HH, MG
CCS	4Y40S, H5

Welding parameters (A)

ϕ mm	1F, 1G	2F	2G	3G uphill, 4G
1.2	150~300	150~300	150~280	150~250
1.4	150~400	150~350	150~300	150~250