DW-55L TRUSTARC™

Flux cored wire

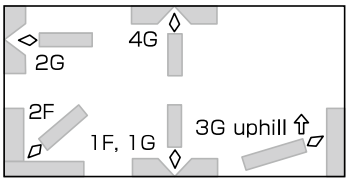
Features: ▪ Excellent impact values down to -60℃

Classification: AWS A5.29 E81T1-K2C

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	0.04	0.15
Si	0.38	0.80
Mn	1.32	0.50~1.75
P	0.010	0.030
S	0.008	0.030
Ni	1.51	1.00~2.00
Cr	0.02	0.15
Mo	0.01	0.35
V	0.02	0.05

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	550	469min.
TS (MPa)	620	552~689
El on 4d (%)	27	22min.
IV -60℃ (J)	70	27min.

Approvals

ABS	3YSA, 5Y400SA, MG, H5
LR	5Y40S, 5Y40M, H5
DNV	VY40MS (H5)
BV	SA5Y40M H5
NK	KSWL3G (C), KSWL3G (C) H5-TS540M, KSW54Y40G (C), H5
KR	L 3SG (C) H5, 5Y40SG (C) H5
CCS	5Y40S 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