DW-55LSR TRUSTARC™

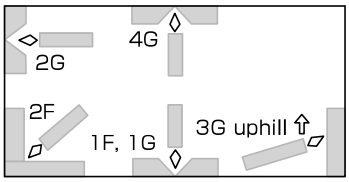
Flux cored wire

Features: ▪ Excellent impact value down to -60℃ in the as-welded and PWHT conditions

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
Volume mm	300W, 110H, 300L		

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.06	0.15
Si	0.29	0.80
Mn	1.21	0.50~1.75
P	0.008	0.030
S	0.007	0.030
Ni	1.56	1.00~2.00
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	440	469min.
TS (MPa)	565	530	552~689
El on 4d (%)	33	34	22min.
IV -60℃ (J)	115	100	27min.
PWHT (℃xh)	AW	620X1	AW

Approvals

ABS	5YQ420SA (H5) 4Y400SA (H5)
LR	5Y42S, MG, H5
DNV	VY42MS (H5), MG VL2-4L, 4-4L
BV	SA4Y40M, UP, H5
NK	MG (KSW5Y42G (C) H5)