DW-62L TRUSTARC™

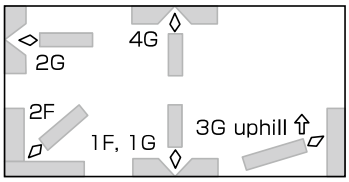
Flux cored wire

Features:
- Excellent impact value down to -60℃
- Excellent CTOD value down to -40℃

Classification: AWS A5.29 E91T1-Ni2C-J

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	0.08	0.12
Si	0.30	0.80
Mn	1.37	1.50
P	0.008	0.030
S	0.010	0.030
Ni	2.57	1.75~2.75

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)	580	538min.
TS (MPa)	650	621~758
El on 4d (%)	25	17min.
IV -60℃ (J)	93	27min.

Approvals

ABS	5YQ500 H5
LR	5Y50S, H5
DNV	ⅤY50MS (H5)
BV	SA5Y50M H5
NK	KSW5Y50G (C) H5
RS	5Y50 MS H5