DW-100 FAMILIARC™

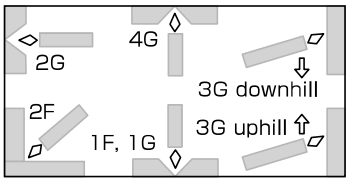
Flux cored wire

Features: ▪ Soft and stable arc, less fume and spattering, smooth bead appearance, and good slag removal

Classification: AWS A5.20 E71T-1C

Shielding gas: CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool			Drum	
1.2	12.5kg	15kg	20kg	250kg	-
1.4	-	15kg	20kg	250kg	350kg
1.6	-	15kg	20kg	-	350kg
Volume mm	300W, 110H, 300L			530ϕ, 820H	680ϕ, 770H

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.05	0.12
Si	0.45	0.90
Mn	1.35	1.75
P	0.01	0.03
S	0.01	0.03
Ni	0.01	0.50
Cr	0.02	0.20
Mo	0.01	0.30
Cu	0.02	0.35
V	0.01	0.80

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	510	400min.
TS (MPa)	570	490~655
El on 4d (%)	30	22min.
IV -18℃ (J)	85	27min.

Approvals

ABS	2YSA, 2Y400SA, H10
LR	2YS, 2YM, H10
DNV	ⅡYMS, ⅡY40MS,H10
BV	SA2M, SA2YM, SA2Y40M H10
NK	KSW52Y40G (C) H10
CR	2YS-HH
KR	2YSG (C)
CCS	2SH10, 2YSH10

Welding parameters (A)

ϕ mm	1F, 1G, 2F	2G	3G uphill, 4G	3G downhill
1.2	120~300	120~280	120~260	200~300
1.4	160~350	160~320	160~270	220~300
1.6	200~400	200~350	200~280	250~300