DW-100KS FAMILIARC™

Flux cored wire

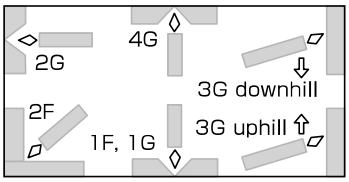
Features: ▪ Suitable for shipping class steel down to -40℃

Classification: AWS A5.20 E71T-1C, E71T-9C-J

Shielding gas: CO_2

Polarity: DCEP

Welding Positions:



Packaging data

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

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.05	0.12
Si	0.54	0.90
Mn	1.47	1.75
P	0.01	0.03
S	0.01	0.03
Ni	0.33	0.50
Cr	0.03	0.20
Mo	0.01	0.30
V	0.01	0.08
Cu	0.02	0.35

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	525	400min.
TS (MPa)	600	483~655
El on 4d (%)	28	22min.
IV -40℃ (J)	100	27min.

Approvals

ABS	4YSA, 4Y400SA, H5
LR	4Y40S H5
DNV	ⅣY40MS, H10
BV	SA4Y40M H5
NK	KSW54Y40G (C) H5
KR	4Y40SG (C) H5

Welding parameters (A)

ϕ mm	1F, 1G	2F	2G	3G uphill, 4G	3G downhill
1.2	120~300	120~300	120~280	120~260	200~300
1.4	150~400	150~350	150~320	150~270	220~300