DW-460L TRUSTARC™

Flux cored wire

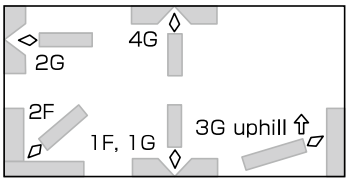
Features:
- Suitable for YP47 grade hull structural steel plates
- Excellent impact value down to -60℃

Classification: AWS -

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	0.04	0.15
Si	0.43	0.80
Mn	1.53	0.50~1.75
P	0.009	0.030
S	0.007	0.030
Ni	1.56	1.00~2.00

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	460min.
TS (MPa)	650	570~720
El on 4d (%)	25	20min.
IV -20℃ (J)	140	57min.

Approvals

ABS	5YQ460H5
LR	5Y46S, 3Y47S H5
DNV	ⅤY46MSH5
BV	SA3Y47MH5, SA5Y46MH5
NK	KSW5Y46G (C) H5, KSW63Y47G (C) H5
KR	5Y46SMG (C1), H5
CCS	For YP47 Steel Plate