DW-A55E FAMILIARC™

Flux cored wire

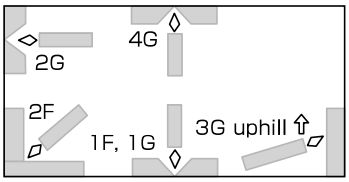
Features: ▪ Excellent impact values down to -40℃

Classification: AWS A5.20 E71T-9M-J

Shielding gas: Ar-20%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	0.05	0.12
Si	0.54	0.90
Mn	1.31	1.75
P	0.01	0.03
S	0.01	0.03
Ni	0.34	0.50
Cr	0.02	0.20
Mo	0.01	0.30
Cu	0.02	0.35
V	0.01	0.08

Note: [a] Single values are maximum.

All-weld mechanical properties

	Typical	Guaranty
0.2%YS (MPa)	540	400min.
TS (MPa)	600	483~655
El on 4d (%)	28	22min.
IV -40℃ (J)	100	27min.

Approvals

ABS	4Y400SA (H5)
LR	4Y40S, H5
DNV	ⅣYMS (H5)
BV	SA4Y40M H5

Welding parameters (A)

ϕ mm	1F, 1G	2F	2G	3G uphill, 4G
1.2	150~300	150~300	150~280	150~250