DW-A55ESR FAMILIARC™

Flux cored wire

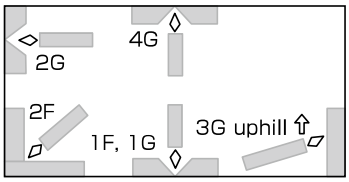
Features: ▪ Excellent impact value down to -46℃

Classification: AWS A5.20 E71T-12M-J

Shielding gas: Ar-20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool	
1.2	5kg	20kg
1.6	-	20kg
Volume mm	220W, 130H, 435L/4pcs	300W, 110H, 300L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.06	0.12
Si	0.50	0.90
Mn	1.40	1.60
P	0.01	0.03
S	0.01	0.03
Ni	0.40	0.50
Cr	0.02	0.20
Mo	0.01	0.30
V	<0.01	0.08
Cu	0.02	0.35

Note: [a] Single values are maximum.

Welding parameters (A)

ϕ mm	1F, 1G, 2F, 2G	3G uphill, 4G
1.2	100~250	120~250
1.6	150~340	180~280

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	500	470	400min.
TS (MPa)	580	560	483~620
El on 4d (%)	30	31	22min.
IV -46℃ (J)	100	60	27min.
PWHT (℃xh)	AW	620x3	AW

Approvals

ABS	4Y400SA, H5
CWB	E491T-12MJ-H8