DW-A55L TRUSTARC™

Flux cored wire

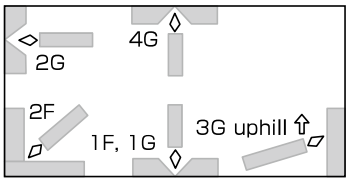
Features: ▪ Excellent impact values down to -60℃

Classification: AWS A5.29 E81T1-K2M

Shielding gas: Ar-20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

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

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.06	0.15
Si	0.32	0.80
Mn	1.17	0.50~1.75
P	0.008	0.030
S	0.008	0.030
Ni	1.53	1.00~2.00
Cr	0.02	0.15
Mo	0.01	0.35
V	0.02	0.05

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)	560	469min.
TS (MPa)	630	552~689
El on 4d (%)	27	22min.
IV -60℃ (J)	94	27min.

Approvals

ABS	3YSA, MG
LR	5Y46S, H5
DNV	VY46MS (H5)
BV	SA5Y46 H5
CCS	5Y46SH5