DW-A55LSR TRUSTARC™

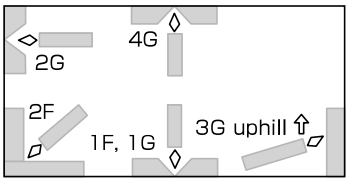
Flux cored wire

Features:
- Excellent impact value down to -60℃ in the as-welded and PWHT conditions
- Meets the NACE MR0175 requirements for both chemistry and hardness. The nickel content is normally 1% max.

Classification: AWS A5.29 E81T1-Ni1M

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	0.07	0.12
Si	0.31	0.80
Mn	1.37	1.50
P	0.008	0.030
S	0.008	0.030
Ni	0.93	0.80~1.00
Cr	0.01	0.15
Mo	0.01	0.35
V	<0.01	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)	510	450	469min.
TS (MPa)	570	530	552~689
El on 4d (%)	29	33	22min.
IV -60℃ (J)	120	70	27min.
PWHT (℃xh)	AW	620x2	AW

Approvals

ABS	5YQ420SA (H5)
LR	5Y42S (H5)
DNV	VY42MS (H5), MG, VL2-4L, 4-4L
BV	SA5Y42 H5
CCS	5Y42S, H5