DW-A62LSR TRUSTARC™

Flux cored wire

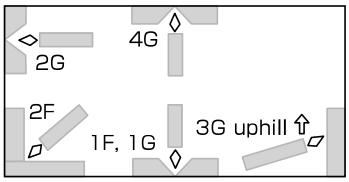
Features:
- Excellent impact value down to -60℃ in the as-welded condition and -40℃ in PWHT condition

Classification: AWS A5.29 E91T1-GM

Shielding gas: Ar-20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool
1.2	12.5kg
Volume mm	300W, 110H, 300L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.05	0.15
Si	0.15	0.80
Mn	1.30	1.00~1.75
P	0.007	0.030
S	0.008	0.030
Ni	2.59	2.00~2.75
Cr	0.02	0.15
Mo	0.20	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)	610	595	538min.
TS (MPa)	675	660	621~758
El on 4d (%)	23	24	17min.
IV (J)	-60℃:98	-40℃:92	27min.
PWHT (℃xh)	AW	620x2	AW