DW-A65Ni1 TRUSTARC™

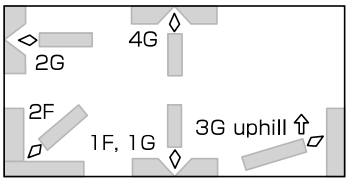
Flux cored wire

Features:
- Suitable for welding up to X70 grade pipe
- Excellent impact value down to -50℃
- The nickel content is normally 1% max.

Classification: AWS A5.29 E91T-GM

Shielding gas: Ar-20%CO_2
Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool	
1.2	5kg	15kg
Volume mm	220W, 130H, 435L/4pcs	300W, 110H, 300L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.05	0.03~0.10
Si	0.33	0.90
Mn	1.51	1.40~2.00
P	0.009	0.020
S	0.008	0.020
Ni	0.95	0.60~1.00
Cr	0.02	0.20
Mo	0.16	0.20
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	538min.
TS (MPa)	670	621~758
El on 4d (%)	23	17min.
IV -50℃ (J)	84	27min.

Approvals

LR	4Y50SH5
DNV	ⅣY50MSH5