DW-A70L TRUSTARC™

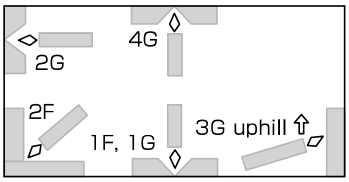
Flux cored wire

Features:
- Suitable for welding up to X80 grade pipe
- Excellent impact value down to -50℃
- The nickel content is normally 1% max.

Classification: AWS A5.29 E101T1-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	0.15
Si	0.36	0.80
Mn	1.90	1.00~2.00
P	0.005	0.030
S	0.008	0.030
Ni	0.89	0.40~1.00
Cr	0.02	0.20
Mo	0.42	0.30~0.70
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)	660	607min.
TS (MPa)	740	690~827
El on 4d (%)	21	16min.
IV -50℃ (J)	70	27min.

Approvals

LR	4Y62S H5
DNV	ⅣY62MS H5