DW-A80L TRUSTARC™

Flux cored wire

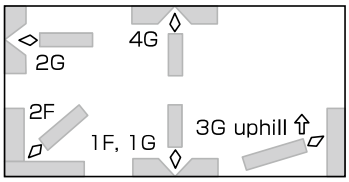
Features: ▪ Excellent impact value down to -40℃

Classification: AWS A5.29 E111T1-GM-H4

Shielding gas: Ar-20%CO_2

Polarity: DCEP

Welding Positions:



Packaging data

ϕ mm	Spool	
1.2	5kg	12.5kg
Volume mm	220W, 130H, 435L/4pcs	300W, 110H, 300L

Composition (all-weld metal mass%)

	Typical	Guaranty [a]
C	0.07	0.12
Si	0.31	0.80
Mn	1.86	1.25~2.25
P	0.007	0.030
S	0.006	0.030
Ni	2.49	1.75~2.75
Cr	0.02	0.20
Mo	0.16	0.50
Cu	0.01	0.50

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)	760	676min.
TS (MPa)	810	759~896
El on 4d (%)	21	15min.
IV -40℃ (J)	90	27min.

Approvals

ABS	4YQ690SA H5, MG
LR	4Y69S H5
DNV	ⅣY69MS, MG (H5)
NK	KSW4Y69G (M2) H5