

DWA-55E

Rutile type flux cored wire for mild steel and 490MPa high tensile strength steel for low temperature service

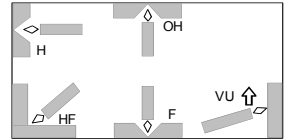
Classification : ASME / AWS A5.20 E71T-9MJ
 EN 758 T42 4 P M 1 H5
 JIS Z3313 YFL-A504R

Features : •Suitable for butt and fillet welding in all positions
 •Excellent impact value at low temperatures down to -40°C

Shielding gas: 80%Ar-20%CO₂ mixture

Polarity: DC-EP

Welding positions:



Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S	Ni
Example	0.05	0.54	1.31	0.013	0.009	0.34
Guaranty	≤0.18	≤0.90	≤1.75	≤0.03	≤0.03	≤0.50

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	540	600	28	-40°C: 100
Guaranty	≥400	≥480	≥22	-40°C ≥27

Recommended welding parameters

Dia.	1.2mm
F	150~300A
HF	150~300A
H	150~280A
VU, OH	150~250A

Approvals

AB	LR	NV	BV	Others
4Y400SA,H5	4Y40S(H5)	IVYMS(H5)	SA3YM HHH	GL, TÜV, U(ic)

Packages

Dia. (mm)	Type	Weight (kg)
1.2	Spool	12.5
	Spool	15