

DW-A55E

80%Ar - 20%CO₂ EN ISO 17632-A-T 42 4 P M 1 H5 AWS A5.20 E71T-9M-J

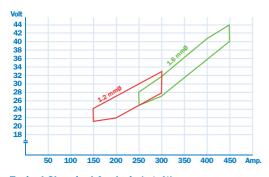
Description and Application

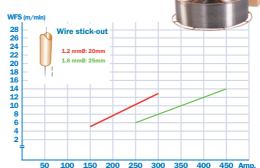
DW-A55E is a rutile flux cored wire that was specially formulated to meet rigorous demands for low temperature service steels. This wire is applied particularly where really good thoughness is required down to -40°C.

The fast freezing slag promotes easy and very productive positional welding with slag removing easily to reveal a weld bead of smooth appearance.

This wire is used for the butt or fillet welding of medium to heavy section carbon steels and is used widely in the shipbuilding and bridge construction industries.

Recommended Parameter Range, for flat position





Typical Chemical Analysis (wt. %)

C	Si	Mn	Р	S	Ni	Cr	Mo
0.05	0.54	1.31	0.013	0.009	0.34	-	-

Typical Mechanical Properties

	R _e (MPa)		A ₅ (%)	CV(J)-40°C	
	540	600	28	100	
Guaranty	min.420	500~640	min.20	min.47	

Example of Diffusible hydrogen content: 4.3 [ml/100g]



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
4Y40S H5	IV YMS H5	SA4Y40M HHH	4Y400SA H5	4Y40MS H5	TÜV,DB,RINA