

## Description and Application

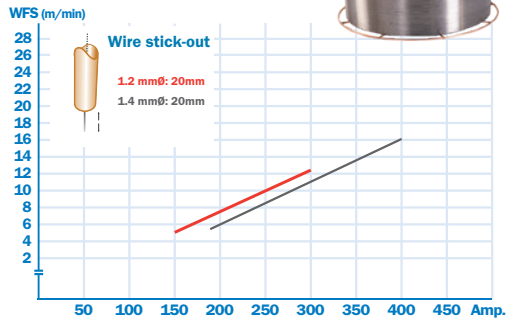
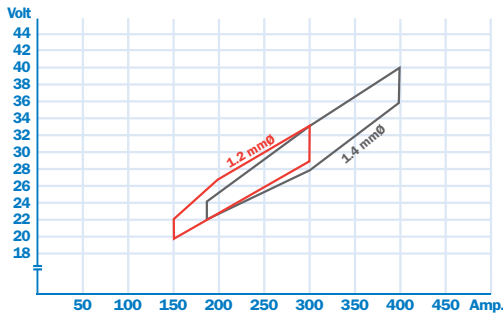
**DW-A55S** is a rutile type flux cored wire with negligible spatter loss, easy slag removal, soft arc, excellent bead profile and appearance.

**DW-A55S** is suited for butt or fillet welding of Y.S.: 460MPa steels.

Due to its good mechanical properties combined with less than 5ml/ 100g hydrogen content in all weld metal (according to EN ISO), this wire is very well suited for constructional steel, bridge construction, tank building, etc.



## Recommended Parameter Range, for flat position



## Typical Chemical Analysis (wt. %)

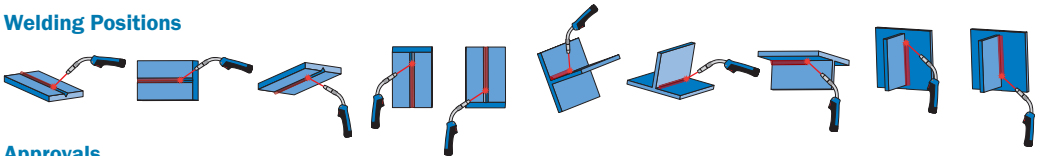
C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.51	1.28	0.010	0.009	-	-	-

## Typical Mechanical Properties

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)-20°C
Guaranty	535	601	24	124
	min.460	530~670	min.22	min.47

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

## Welding Positions



## Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	-