

## Description and Application

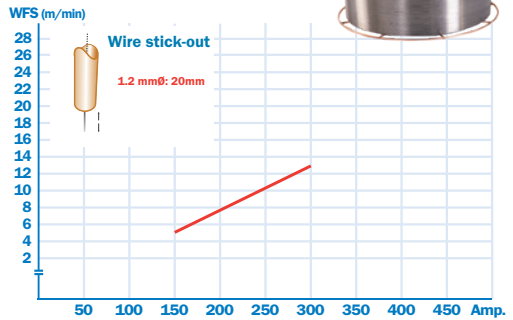
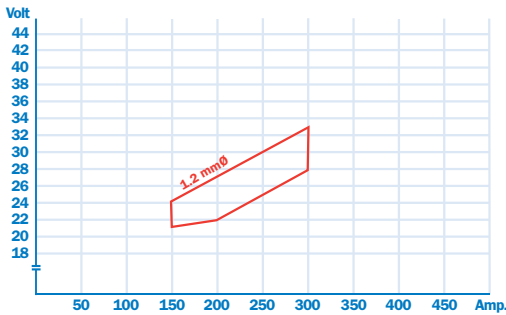
**DW-A55EH** is a rutile flux cored wire that was specially formulated to meet rigorous demands for low temperature service application required really good toughness down to -40°C. This wire also can be used for applications where post weld heat treatment is required depending on the conditions and toughness requirements.

This wire is very versatile due to its excellent welding characteristics. It is an all positional wire with negligible spatter loss, easy slag removal, soft arc, excellent bead profile and appearance, resulting in superb welder appeal.

This wire is used for the butt and fillet welding of medium to heavy section carbon steels and is used in the Offshore and Pressure vessel construction industries.



### Recommended Parameter Range, for flat position



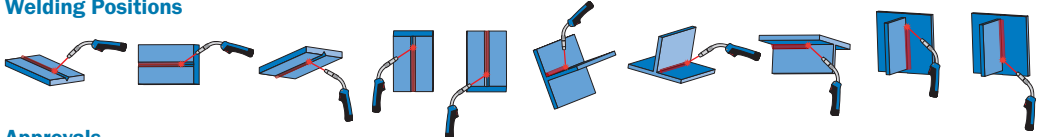
### Typical Chemical Analysis (wt. %)

| C    | Si   | Mn   | P     | S     | Ni   | Cr | Mo |
|------|------|------|-------|-------|------|----|----|
| 0.05 | 0.63 | 1.17 | 0.010 | 0.007 | 0.38 | -  | -  |

### Typical Mechanical Properties

|                      | R <sub>e</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | CV(J)-40°C |
|----------------------|----------------------|----------------------|--------------------|------------|
| As welded            | 561                  | 603                  | 29                 | 133        |
| 620°Cx3hrs(SR)       | 480                  | 580                  | 31                 | 132        |
| Guaranty (As welded) | min.420              | 500-640              | min.20             | min.47     |

### Welding Positions



Example of Diffusible hydrogen content: 4.5 [ml/100g]

### Approvals

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