

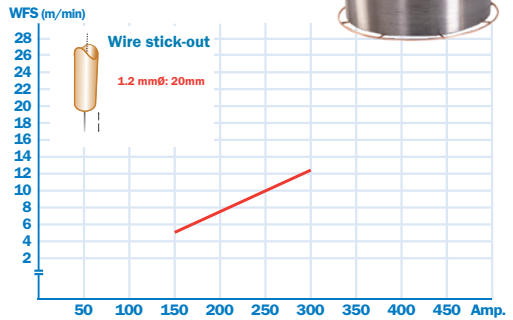
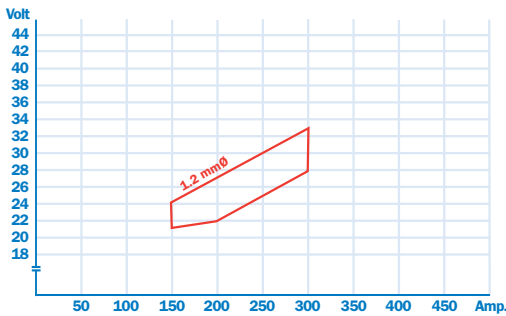
## Description and Application

**DW-A81Ni1** is a rutile flux cored wire which has been specially formulated to meet the rigorous demands for low temperature service steels. This wire can also be used for applications where post weld heat treatment is required depending on the conditions and toughness requirement.

**DW-A81Ni1** fulfills NACE requirements for oil and gas production equipment in sour gas service and these properties make for a varied range of usages in pipeline construction, offshore applications and pressure vessels.



### Recommended Parameter Range, for flat position



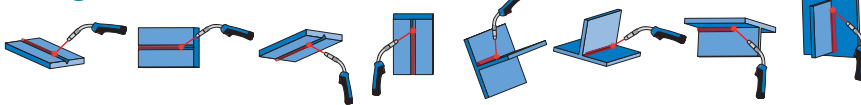
### Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.32	1.26	0.006	0.006	0.95	-	-

### Typical Mechanical Properties

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)-40°C	CV(J)-60°C
As welded	517	582	29	153	142
580°Cx2hr(SR)	490	578	30	139	128
Guaranty (As welded)	min.460	530-680	min.20	-	min.47

### Welding Positions



Example of Diffusible hydrogen content: 4.4 [ml/100g]

### Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
5Y42S H5	VY42MS H5	-	5YQ420SA H5, 4Y400SA H5	5Y42MS H5	TÜV