

Description and Application

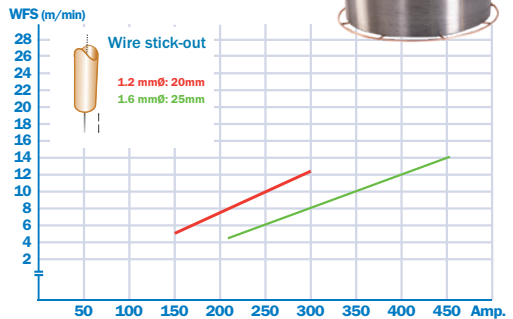
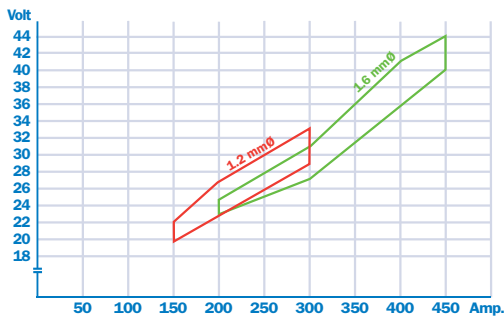
This rutile flux cored wire is very versatile due to its excellent welding characteristics. It is an all positional wire with negligible spatter loss, easy slag removal, soft stable arc, excellent bead profile and appearance, resulting in superb welder appeal.

DW-50 is used for butt or fillet welding of mild and Y.S.: 420MPa 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 work, ship building, bridge construction, tank building, etc.



Recommended Parameter Range, for flat position*



* The above values and parameters are for all weld metal produced using 100%CO₂ shielding gas

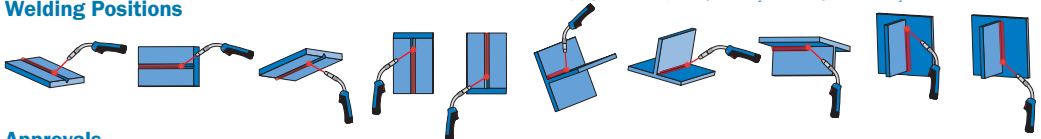
Typical Chemical Analysis (wt. %)

Shielding gas	C	Si	Mn	P	S	Ni	Cr	Mo
100%CO ₂	0.04	0.67	1.29	0.011	0.008	-	-	-
80%Ar-20%CO ₂	0.04	0.69	1.32	0.013	0.009	-	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-20°C	CV(J)-30°C
100%CO ₂	540	607	30	76	68
80%Ar-20%CO ₂	567	626	29	121	89
Guaranty	min.420	500-640	min.20	min.47	min.27

Welding Positions



Example of Diffusible hydrogen content: 3.8 [ml/100g] 100% CO₂, 4.4 [ml/100g] 80%Ar-20%CO₂

Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
3YS H5	III YMS H5	SA3YM H5	3SA,3YSA H5	3YMS,3Y40MS H5	RRR,RINA,CWB