

Description and Application

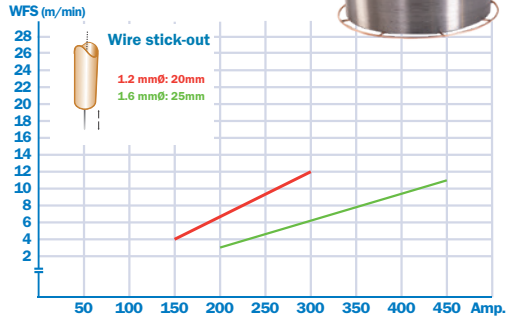
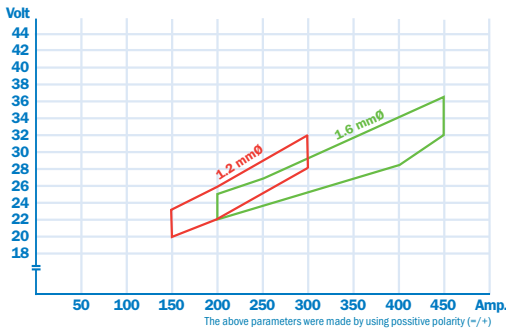
DW-A51B is a fully basic FCW which produces very low hydrogen weld metal of excellent crack resistance.

This wire is particularly suitable for multipass welding of medium to heavy sections where conditions of high restraint exist and where extra low hydrogen levels are necessary.

DW-A51B is also often applied in situations where an ideal joint fit-up can not be achieved, leading to an increased risk of cracking when applying other welding consumables, for example when welding root passes on ceramic backing.



Recommended Parameter Range, for flat position



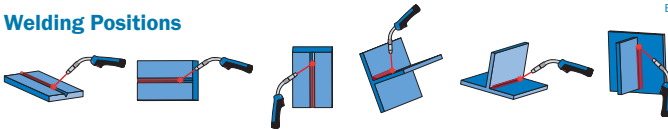
Typical Chemical Analysis (wt. %)

Polarity	C	Si	Mn	P	S	Ni	Cr	Mo
DC+	0.08	0.49	1.43	0.012	0.008	-	-	-
DC-	0.08	0.46	1.45	0.011	0.008	-	-	-

Typical Mechanical Properties

Polarity	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-20°C	CV(J)-40°C
DC+	490	569	29	130	89
DC-	473	560	31	139	127
Guaranty	min.420	500-640	min.20	min.47	min.47

Welding Positions



Example of Diffusible hydrogen content: 4.2 (ml/100g)

Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
3YS H5	III YMS H5	SA3YM H5	-	-	TÜV, DB