

Description and Application

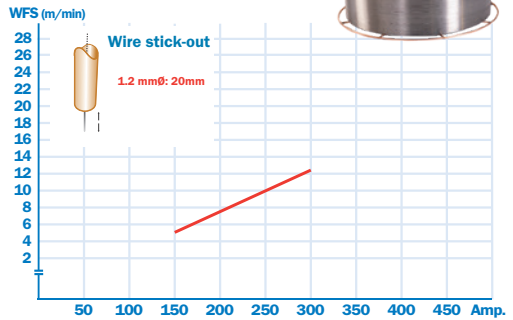
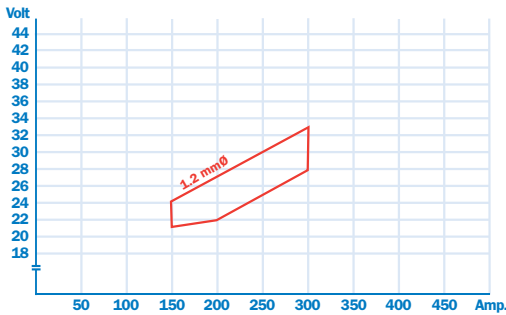
DW-55L is a rutile flux cored wire that has been specially formulated to meet the rigorous demands for low temperature service as found in the offshore, shipbuilding and chemical industries.

This wire has excellent weld metal toughness down to -60°C and still exhibits superb welding characteristics such as a very smooth, but forceful, stable arc producing little spatter and a fast freezing self releasing slag.

This wire is widely applied to the welding of thin to heavy section carbon steels.



Recommended Parameter Range, for flat position



Typical Chemical Analysis (wt. %)

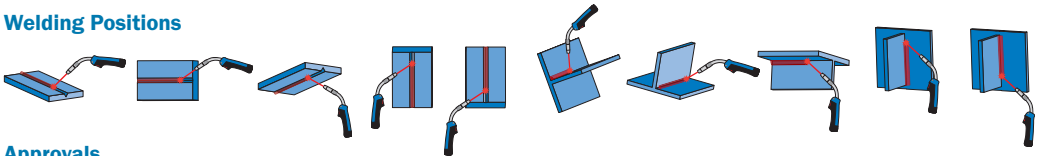
C	Si	Mn	P	S	Ni	Cr	Mo
0.04	0.38	1.32	0.010	0.008	1.40	-	-

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-60°C
Guaranty	min.460	530~680	min.20	min.47

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

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
5Y40S H5	V Y40MS H5	SA5Y40M H5	3YSA H5,5Y400SA H5	-	NK, KR, CCS
	NV2-4L,4-4L		MG		

* The information contained or otherwise referenced herein is presented only as "typical" without guaranty or warranty. Typical data is obtained when welded and tested in accordance with EN or AWS standards. This data is intended to help the user choose the correct product. However, we do not assume any liability for correctness and information is subject to change without notice.