

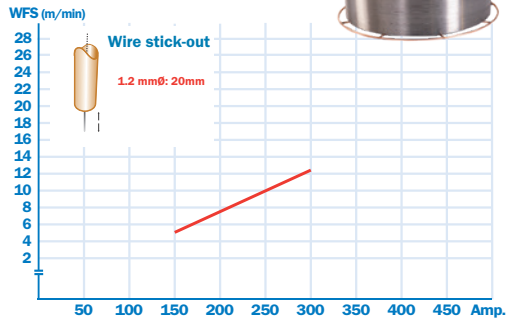
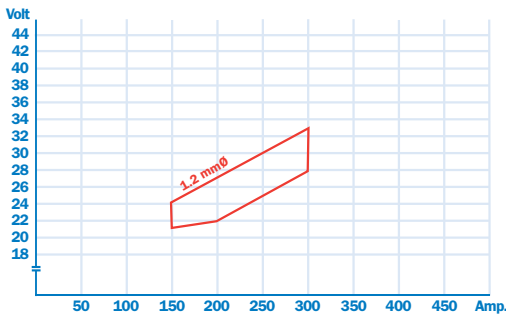
## Description and Application

**DW-55LSR** is a rutile flux cored wire whose weld metal tolerates post weld heat treatment (PWHT) without an adverse degradation of mechanical properties.

These properties make for a varied range of usages in pipeline construction and offshore applications.



### Recommended Parameter Range, for flat position



### Typical Chemical Analysis (wt. %)

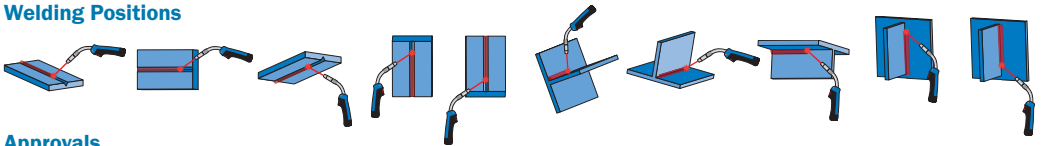
C	Si	Mn	P	S	Ni	Cr	Mo
0.06	0.26	1.15	0.008	0.007	1.51	-	-

### Typical Mechanical Properties

	R <sub>0</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)-60°C
As welded	480	565	33	115
620°C x 1 hr (SR)	440	530	34	100
Guaranty (as welded)	min.460	530~680	min.20	min.47

Example of Diffusible hydrogen content: 4.2 [ml/100g]

### Welding Positions



### Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
5Y42S H5 MG	VY42MS H5 MG NV2-4L,4-4L	SA4Y40M H5 MG	5YQ420SA H5 4Y400SA H5	-	NK