

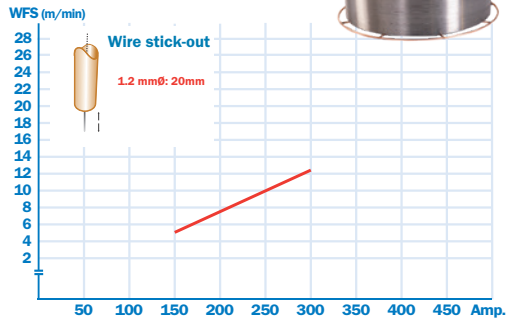
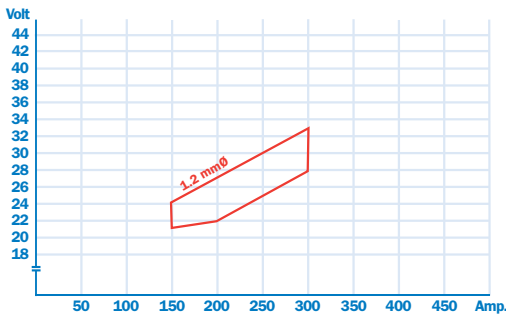
## Description and Application

**DW-A65L** is a rutile flux cored wire specially formulated to meet the rigorous demands for 640 MPa tensile strength class low temperature service steels, as found in the offshore shipbuilding and chemical industries. This wire is applied to the welding of medium to heavy section butt or fillet weld joints.

**DW-A65L** continues to find new applications due to the increasing use of 550 MPa yield strength low temperature service steels.



### Recommended Parameter Range, for flat position



### Typical Chemical Analysis (wt. %)

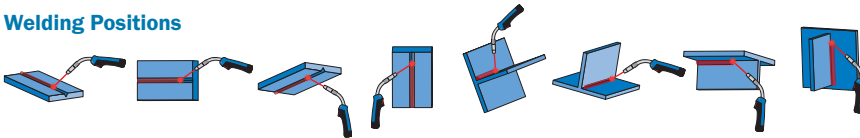
C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.35	1.17	0.010	0.009	1.69	-	0.11

### Typical Mechanical Properties

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)-40°C
Guaranty	min.550	640~820	min.18	min.47

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

### Welding Positions



### Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	-