

## Description and Application

**DW-A55L** 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.

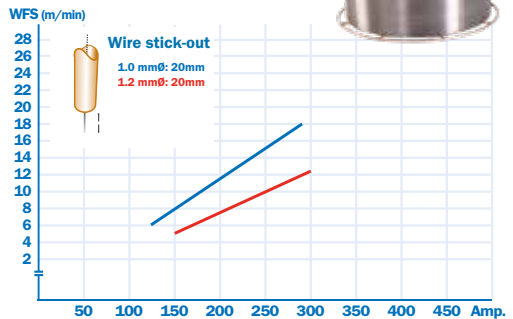
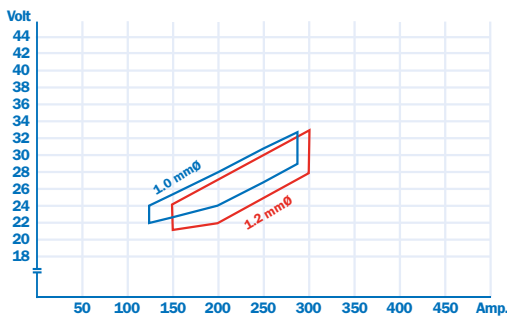
This wire has excellent weld metal toughness down to -60°C and still exhibits superb welding characteristics such as a very smooth, but forceful, stable arc producing little spatter and a fast freezing self releasing slag.

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

Not only does this wire have excellent CTOD values at the standard -10°C test temperature, but is also has excellent CTOD values at the very severe test temperature of -40°C.



### Recommended Parameter Range, for flat position



### Typical Chemical Analysis (wt. %)

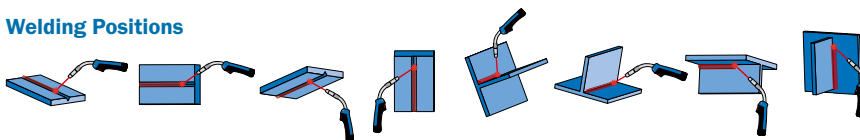
C	Si	Mn	P	S	Ni	Cr	Mo
0.06	0.30	1.15	0.009	0.007	1.41	-	-

### Typical Mechanical Properties

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)-60°C
	558	626	27	94
Guarantee	min.460	530~680	min.20	min.47

Example of Diffusible hydrogen content: 4.5 [ml/100g]

### Welding Positions



### Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
5Y46S H5	VY46MS H5	S5Y46 H5	3YSA H5	5Y46MS H5	RINA, TÜV
	NV2-4,4-4		3SA		P.R.S.