

80%Ar - 20%CO<sub>2</sub>

EN ISO 17632-A-T 42 4 P M 1 H5

AWS A5.20 E71T-9M-J

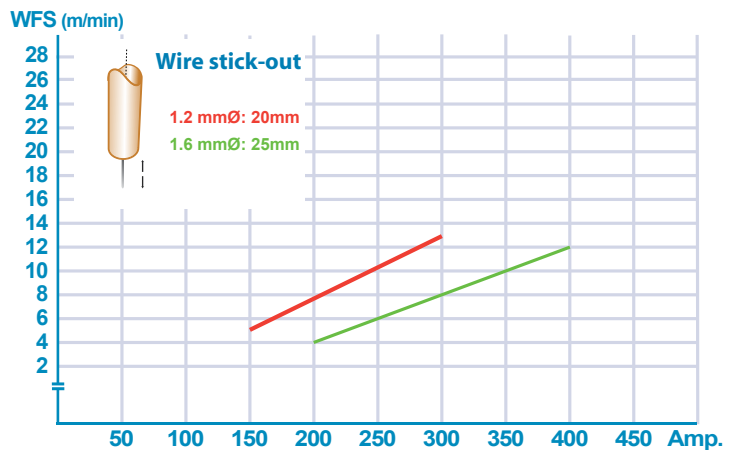
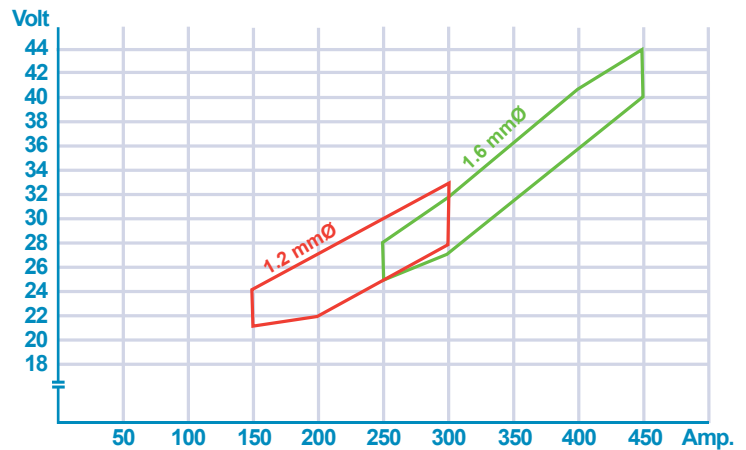
## Description and Application

FAMILIARC™ DW-A55E is a rutile flux cored wire that was specially formulated to meet rigorous demands for low temperature service steels. This wire is applied particularly where really good toughness is required down to -40°C.

The fast freezing slag promotes easy and very productive positional welding with slag removing easily to reveal a weld bead of smooth appearance.

This wire is used for the butt or fillet welding of medium to heavy section carbon steels and is used widely in the shipbuilding and bridge construction industries.

## Recommended Parameter Range, for flat position



## Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.54	1.31	0.013	0.009	0.34	-	-

## Typical Mechanical Properties

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)-40°C
	540	600	28	100
Guarantee	min.420	500~640	min.20	min.47

## Welding Positions



## Approvals

LR	DNV	BV	GL	ABS	R.M.R.S	Others
4Y40S	IV YMS	SA4Y40M	4Y40S	4Y400SA	-	TÜV,DB,RINA