

DW-50 **FAMILIARC™**

Rutile type flux cored wire

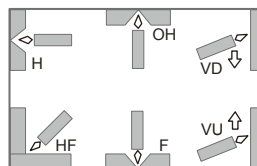
Classification: ASME / AWS A5.20 E71T-1C/1M, -9C/9M
EN ISO 17632-A - T 42 2 P C/M 1 H5

- Features:**
- Suitable for butt and fillet welding in all positions including vertical downward
 - Excellent usability with soft and stable arc, less fume and spattering, good bead appearance and smooth slag removal
 - Applicable for ship class E-grade plates

Shielding gas: CO₂ or Ar-CO₂ mixture

Polarity: DC-EP

Welding positions:



Chemical composition of all-weld metal (%) as per AWS (Shielding gas: CO₂)

	C	Si	Mn	P	S
Example	0.04	0.67	1.29	0.011	0.008
Guaranty	≤0.12	≤0.90	≤1.75	≤0.03	≤0.03

Mechanical properties of all-weld metal as per AWS (Shielding gas: CO₂)

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	510	582	27	-29°C: 71
Guaranty	≥400	≥490	≥22	-29°C ≥27

Recommended welding parameters

Dia.	1.2mm	1.6mm
F	120~250A	180~340A
HF	120~250A	180~340A
H	120~250A	180~340A
VU, OH	120~250A	180~280A
VD	200~250A	250~300A

Approvals

ABS	LR	DNV	NK	Others
3YSA,H5	3YS,H5	IIIYMS(H5)	KSW53G(C)H5	GL: 3YH5S CWB

Packages

Dia. (mm)	Type	Weight (kg)	Dia. (mm)	Type	Weight (kg)	Dia. (mm)	Type	Weight (kg)
1.1	Spool	5	1.2	Spool	15	1.6	Spool	15
	Spool	12.7					Spool	20
	Spool	20					Pack	250
	Pack	250						