

DW-A50 FAMILIARC™

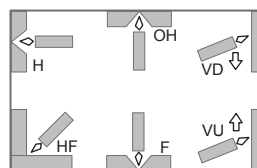
Rutile type flux cored wire

Classification: ASME / AWS A5.20 E71T-1M
 EN ISO 17632-A - T 42 2 P M 1 H5
 JIS Z3313 T49J0T1-1MA-U

Features: •Suitable for butt and fillet welding in all position including vertical downward
 •Excellent usability with soft and stable arc, less fume and spattering, good bead appearance and smooth slag removal

Shielding gas: Ar-CO₂ mixture
Polarity: DC-EP

Welding positions:



Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S
Example	0.05	0.48	1.22	0.013	0.009
Guaranty	≤0.12	≤0.90	≤1.75	≤0.03	≤0.03

Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	510	570	30	-18°C: 110
Guaranty	≥400	≥490	≥22	-18°C ≥27

Recommended welding parameters

	1.2mm	1.6mm		1.2mm	1.6mm
Dia.	1.2mm	1.6mm	Dia.	1.2mm	1.6mm
F	120~300A	180~450A	VU, OH	120~260A	180~280A
HF	120~300A	180~400A	VD	200~300A	250~300A
H	120~280A	180~350A			

Approvals

ABS	LR	DNV	BV	NK	Others
3YSA,H5	3YS,H5	III YMS(H5),MG	SA3YM HHH	KSW52G(M2)H5	GL: 3YH5S TÜV, U(ic), DB

Packages

Dia. (mm)	Type	Weight (kg)	Dia. (mm)	Type	Weight (kg)	Dia. (mm)	Type	Weight (kg)
1.1	Spool	15	1.2	Spool	15	1.6	Spool	15
	Spool	20		Spool	20			