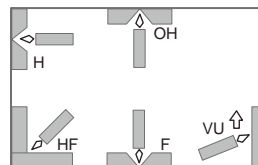


**DW-A55E** **TRUSTARC™**

**Rutile type flux cored wire**

**Classification:** ASME / AWS A5.20 E71T-9M-J  
 EN ISO 17632-A - T 42 4 P M 1 H5  
**Features:** •Suitable for butt and fillet welding in all positions  
 •Excellent impact value at low temperatures down to -40°C  
**Shielding gas:** 80%Ar+20%CO<sub>2</sub> mixture  
**Polarity:** DC-EP

**Welding positions:**



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

	C	Si	Mn	P	S	Ni
Example	0.05	0.54	1.31	0.013	0.009	0.34
Guaranty	≤0.12	≤0.90	≤1.75	≤0.03	≤0.03	≤0.50

**Mechanical properties of all-weld metal as per AWS**

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV (J)
Example	540	600	28	-40°C: 100
Guaranty	≥400	≥480	≥22	-40°C ≥27

**Recommended welding parameters**

Dia.	1.2mm
F	150~300A
HF	150~300A
H	150~280A
VU, OH	150~250A

**Approvals**

ABS	LR	DNV	BV	GL	Others
4Y400SA(H5)	4Y40S,H5	IVYMS(H5)	SA4Y40M HHH	3YH5S	TÜV, U(ic)

**Packages**

Dia. (mm)	Type	Weight (kg)
1.2	Spool	12.5
	Spool	15