

FCAW

# DW-460L

**TRUSTARC™**

## Flux cored wire

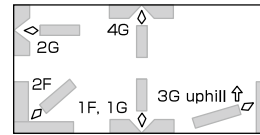
- Features:**
- Suitable for YP47 grade hull structural steel plates
  - Excellent impact value down to -60°C

**Classification:** AWS -

**Shielding gas:** CO<sub>2</sub>

**Polarity:** DCEP

### Welding Positions:



## Packaging data

φ mm	Spool	
	1.2	12.5kg
<b>Volume mm</b>	300W, 110H, 300L	

## Composition (all-weld metal mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.04	0.15
<b>Si</b>	0.43	0.80
<b>Mn</b>	1.53	0.50~1.75
<b>P</b>	0.009	0.030
<b>S</b>	0.007	0.030
<b>Ni</b>	1.56	1.00~2.00

Note: <sup>a</sup> Single values are maximum.

## Welding parameters (A)

φ mm	1F,1G, 2F	2G	3G uphill, 4G
1.2	150~300	150~280	150~250

## All-weld mechanical properties

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	580	460min.
<b>TS (MPa)</b>	650	570~720
<b>EI on 4d (%)</b>	25	20min.
<b>IV -20°C (J)</b>	140	57min.

## Approvals

<b>ABS</b>	5YQ460H5
<b>LR</b>	5Y46S, 3Y47S H5
<b>DNV-GL</b>	VY46MSH5
<b>BV</b>	SA3Y47MH5, SA5Y46MH5
<b>NK</b>	KSW5Y46G (C) H5, KSW63Y47G (C) H5
<b>KR</b>	5Y46SMG (C1), H5
<b>CCS</b>	For YP47 Steel Plate