

FCAW

DW-A65Ni1

TRUSTARC™

Flux cored wire

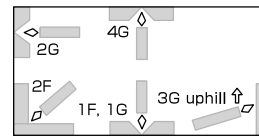
- Features:**
- Suitable for welding up to X70 grade pipe
 - Excellent impact value down to -50°C
 - The nickel content is normally 1% max.

Classification: AWS A5.29 E91T-GM

Shielding gas: Ar-20%CO₂

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Spool	
	5kg	15kg
1.2		
Volume mm	220W, 130H, 435L/4pcs	300W, 110H, 300L

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.05	0.03~0.10
Si	0.33	0.90
Mn	1.51	1.40~2.00
P	0.009	0.020
S	0.008	0.020
Ni	0.95	0.60~1.00
Cr	0.02	0.20
Mo	0.16	0.20
V	<0.01	0.05

Note: ^a 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
0.2%YS (MPa)	610	538min.
TS (MPa)	670	621~758
EI on 4d (%)	23	17min.
IV -50°C (J)	84	27min.

Approvals

LR	4Y50SH5
DNV-GL	IVY50MSH5