

FCAW

DW-A62LSR

TRUSTARC™

Flux cored wire

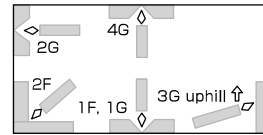
Features: ■ Excellent impact value down to -60°C in the as-welded condition and -40°C in PWHT condition

Classification: AWS A5.29 E91T1-GM

Shielding gas: Ar-20%CO₂

Polarity: DCEP

Welding Positions:



Packaging data

φ mm	Spool
1.2	12.5kg
Volume mm	300W, 110H, 300L

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.05	0.15
Si	0.15	0.80
Mn	1.30	1.00~1.75
P	0.007	0.030
S	0.008	0.030
Ni	2.59	2.00~2.75
Cr	0.02	0.15
Mo	0.20	0.35
V	<0.01	0.05

Welding parameters (A)

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

Note: ^a Single values are maximum.

All-weld mechanical properties

	Typical		Guaranty
0.2%YS (MPa)	610	595	538min.
TS (MPa)	675	660	621~758
EI on 4d (%)	23	24	17min.
IV (J)	-60°C:98	-40°C:92	27min.
PWHT (°C×h)	AW	620×2	AW