

FCAW

# DW-A55E

# FAMILIARC™

## Flux cored wire

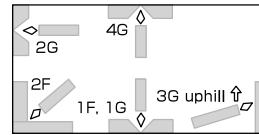
**Features:** ■ Excellent impact values down to -40°C

**Classification:** AWS A5.20 E71T-9M-J

**Shielding gas:** Ar-20%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>	0.05	0.12
<b>Si</b>	0.54	0.90
<b>Mn</b>	1.31	1.75
<b>P</b>	0.01	0.03
<b>S</b>	0.01	0.03
<b>Ni</b>	0.34	0.50
<b>Cr</b>	0.02	0.20
<b>Mo</b>	0.01	0.30
<b>Cu</b>	0.02	0.35
<b>V</b>	0.01	0.08

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

## All-weld mechanical properties

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	540	400min.
<b>TS (MPa)</b>	600	483~655
<b>EI on 4d (%)</b>	28	22min.
<b>IV -40°C (J)</b>	100	27min.

## Approvals

<b>ABS</b>	4Y400SA (H5)
<b>LR</b>	4Y40S, H5
<b>DNV-GL</b>	IVYMS (H5)
<b>BV</b>	SA4Y40M H5

## Welding parameters (A)

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