



# Elgacore DW 588

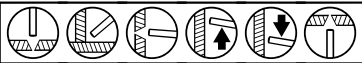
FCAW - Flux cored arc welding  
Un-alloyed

Date: 2010-10-15  
Revision: 13

### Description:

Elgacore DW 588 is a rutile flux cored wire for use with a CO<sub>2</sub> gas shield and deposits a 0.5% Ni / 0.5% Cr / 0.4% Cu weld metal designed for welding weather-resisting steels similar to Cor-Ten. The weld metal also resists preferential corrosion in seawater. Elgacore DW 588 is all-positional and runs with a very stable, smooth arc. The combination of negligible spatter, easily detached slag and smooth bead finish minimises the need for post-weld dressing and contributes to increased productivity.

### Welding positions:



### Welding current:

DC+

### Deposition efficiency:

87%

### Shielding gas:

C1, 100% CO<sub>2</sub>, 22-25 l/min

### Stick-out:

15-25 mm

### Hydrogen content / 100 g weld metal

≤ 5 ml

### Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0.35	0.50			0.45	0.4
Typical	0.04	0.6	1.2	0.014	0.01	0.5	0.5
Max	0.12	0.80	1.30	0.03	0.03	0.70	0.80

	Mo	Cu	V	Nb
Min		0.30		
Typical		0.4		
Max	0.35	0.75	0.05	0.05

### Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 500 MPa	530 MPa
Tensile Strength, Rm:	560-690 MPa	610 MPa
Elongation, A5	≥ 19%	26%
Impact energy, CV:	-20°C • 47 J	-30°C • 50 J

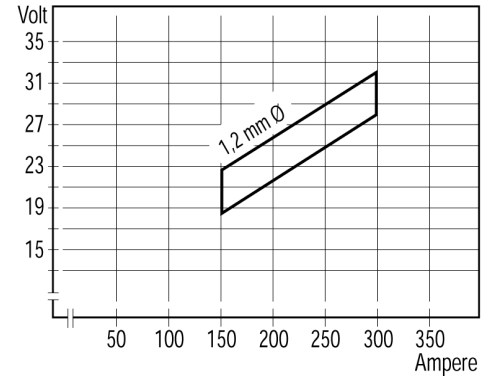
### Classification:

ISO 17632-A

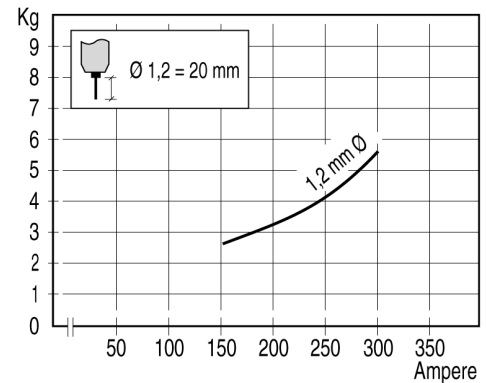
T 50 2 Z P C 1 H10

### Approvals:

### Recommended parameter range:



### Deposition rate per hour:



### Product data:

Diam.mm	Product code	Spool weight
1,2	95582012	15 kg D300

### Note

Strip:  
S ≤ 0.012%  
P ≤ 0.015%  
N ≤ 0.004%