



Elgacore DWA 50

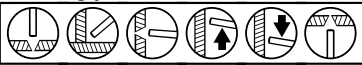
FCAW - Flux cored arc welding
Un-alloyed

Date: 2013-05-27
Revision: 15

Description:

Elgacore DWA 50 is a rutile flux cored wire for use with an Ar/CO₂ gas shield. The wire is all-positional and runs with a very stable, soft arc producing excellent weld bead shape and finish with negligible spatter. The slag is easily detachable and fume emission is very low. It is suitable for welding mild and medium strength carbon manganese structural steels and produces excellent root beads on ceramic backing. Ease of use and high productivity, in combination with good mechanical properties and a weld metal hydrogen content less than 5 ml/100g, make Elgacore DWA 50 an extremely versatile general purpose cored wire.

Welding positions:



Welding current:

DC+

Deposition efficiency:

88%

Shielding gas:

M21, 80% Ar + 20% CO₂, 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							
Typical	0.06	0.4	1.2	0.015	0.007		
Max	0.18	0.90	1.75	0.03	0.03	0.20	0.50

	Mo	Cu	V	Nb
Min				
Typical				
Max	0.20	0.30	0.08	0.05

Mechanical properties

	Specified	Typical
Yield strength, Re:	≥ 420 MPa	520 MPa
Tensile Strength, Rm:	500-640 MPa	590 MPa
Elongation, A5	≥ 22%	28%
Impact energy, CV:	-20°C • 47 J	-20°C • 75 J

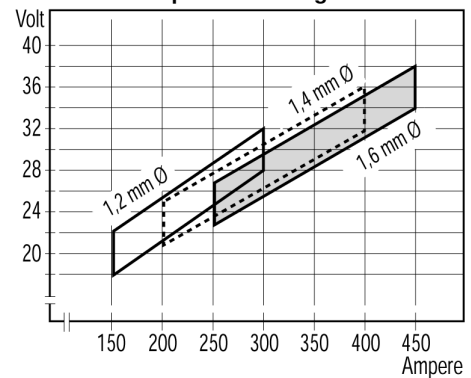
Classification:

EN 758	T 42 2 P M 1 H5
AWS A5.20	E 71T-1M
ISO 17632-A	T 42 2 P M 1 H5

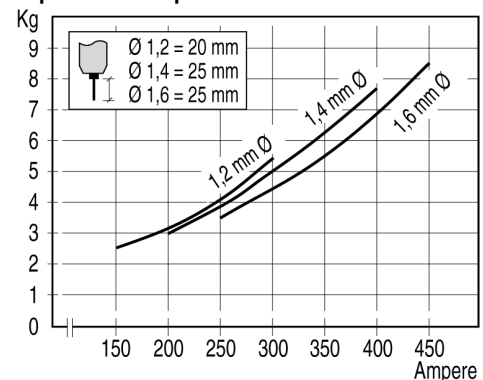
Approvals:

ABS	3YSA H5
DNV	III YMS H5
LR	3S, 3YS H5
DB	42.042.09
MRS	3Y40MS HHH
TÜV	07375.01
GL	3 YH5S
RINA	3YS
BV	SA 3Y M HHH
CE	

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Spool weight
1,2	95601012	15 kg BS300
1,2	95602112	5 kg D200
1,2	95602212	250 kg ProPac
1,6	95602016	12,5 kg D300

Note

Strip:
S ≤ 0.015%

P ≤ 0.025%
N ≤ 0.004%