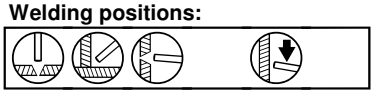
Elgacore DWA 52F

FCAW - Flux cored arc welding
Un-alloyed

Date:	2013-05-27
Revision:	8

Description:
Elgacore DWA 52F is a rutile flux cored wire especially designed for welding standing fillets (2F/PB), and produces a mitre bead profile and exceptionally smooth bead surface. This wire operates with a soft but deep penetrating arc which produces negligible spatter loss combined with easy slag removal.

Welding positions:



Welding current:
DC+

Deposition efficiency:
90%

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	0.05	0.54	1.35	0.012	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

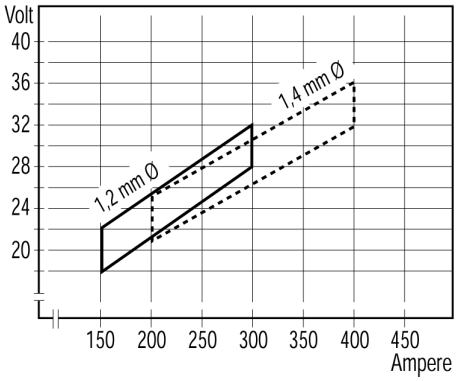
	Specified	Typical
Yield strength, Re:	≥ 420 MPa	500 MPa
Tensile Strength, Rm:	500-640 MPa	590 MPa
Elongation, A5	≥ 22%	30%
Impact energy, CV:	–20℃ • 47J	–20℃ • 65J

Classification:

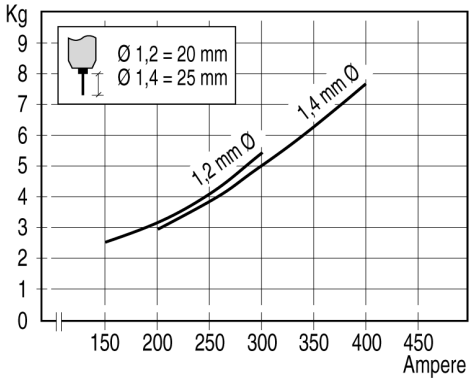
EN 758	T 42 2 R M 1 H5
AWS A5.20	E71T-1M
ISO 17632-A	T 42 2 R M 1 H5

Approvals:

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Spool weight
1,2	95502012	15 kg D300
1,4	95502014	15 kg D300

Note

Strip:
S ≤ 0.015%
P ≤ 0.025%
N ≤ 0.004%