



Elgacore DWX 50

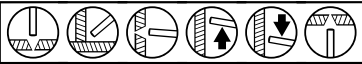
FCAW - Flux cored arc welding
Un-alloyed

Date: 2013-05-27
Revision: 9

Description:

Elgacore DWX 50 is a rutile flux cored wire for use with an Ar/CO₂ or straight CO₂ gas shield. Elgacore DWX 50 is mainly developed for welding on thinner materials where low current and small fillets are required. 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, makes Elgacore DWX 50 an extremely versatile cored wire for material thicknesses down to 5mm.

Welding positions:



Welding current:

DC+

Deposition efficiency:

88%

Shielding gas:

M21, 80% Ar+20% CO₂, 22-25 l/min
C1, 100% 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	0.5	1.4	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	540 MPa
Tensile Strength, Rm:	500-640 MPa	600 MPa
Elongation, A5	≥ 22%	28%
Impact energy, CV:	-20°C • 47 J	-20°C • 75 J

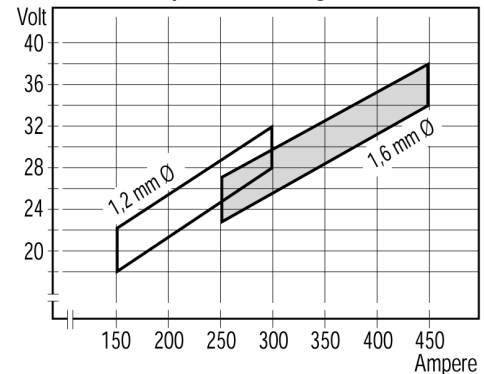
Classification:

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

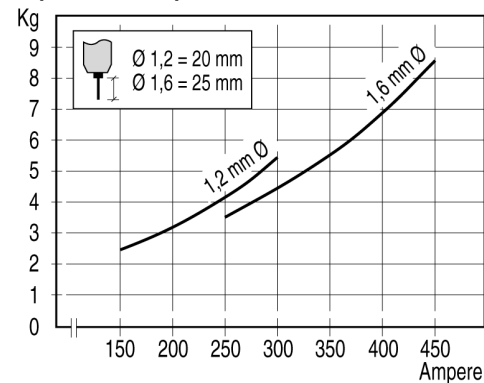
Approvals:

ABS 3YSA H5
GL 3YH5S
DNV III YMS H5
LR 3S, 3YS H5
RINA 3YS
MRS 3Y40MS HHH
CE

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Spool weight
1,2	95872112	5 kg D200
1,2	95871012	15 kg BS300
1,2	95871112	5 kg BS200
1,6	95871016	15 kg BS300

Note

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

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