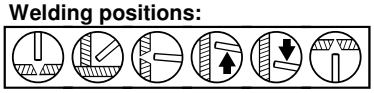
Elgacore DWA 55LSR

FCAW - Flux cored arc welding
Low-alloyed

Date:	2013-05-27
Revision:	12

Description:
Elgacore DWA 55LSR is a rutile flux cored wire producing a nominal 0.9 % Ni weld metal that tolerates PWHT without degradation of mechanical properties. It is designed to give excellent fracture toughness at temperatures down to –60°C, both in the as-welded and stress relieved condition. The wire offers exceptional all-positional operability combined with high productivity and is especially suitable for pipe welding. Elgacore DWA 55LSR fulfils NACE requirements for oil and gas production equipment in sour service and also has excellent CTOD values, making it a natural choice for offshore applications.

Welding positions:



Welding current:
DC+

Hydrogen content / 100 g weld metal
≤ 5 ml

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min		0,2					0,8
Typical	0,06	0,3	1,3	0,010	0,005	0,015	0,9
Max	0,12	0,8	1,5	0,03	0,03	0,15	1,0

	Mo	Cu	V	Ti	B	Nb
Min					0,002	
Typical	0,01	0,02	0,01	0,05	0,004	0,005
Max	0,20	0,30	0,05		0,005	0,05

Mechanical properties

	Specified	Typical	PWHT Typical
Yield strength, Re:	≥ 420 MPa	500 MPa	450 MPa
Tensile Strength, Rm:	500-640 MPa	570 MPa	540 MPa
Elongation, A5	≥ 20%	30%	32%
Impact energy, CV:	–60°C • 47 J	–60°C • 80 J	–46°C • 85 J 610°C X 2h

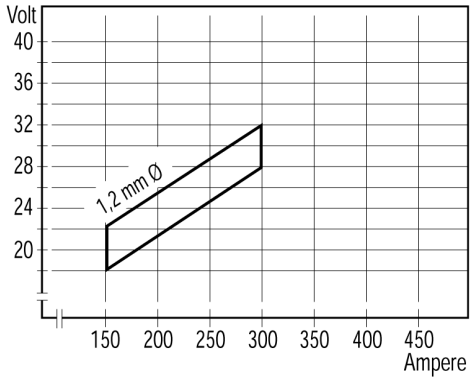
Classification:

EN 758	T 46 6 Z P M 1 H5
AWS A5.29	E 81 T1-Ni1M
ISO 17632-A	T 46 6 Z P M 1 H5

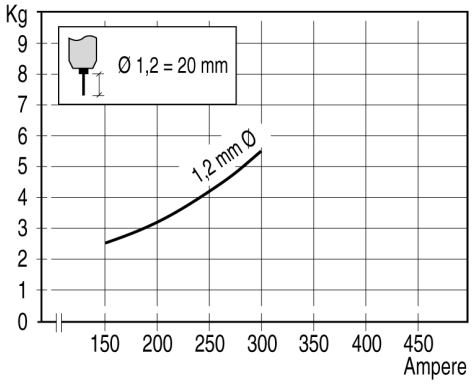
Approvals:

DNV	V Y42MS H5
ABS	5YQ420 SA H5
BV	SA 5Y42 H5
CE	

Recommended parameter range:



Deposition rate per hour:



Product data:

Diam.mm	Product code	Spool weight
1,2	95522012	12,5 kg D300
1,2	95522112	5 kg D200

Note

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