

FAMILIARC™ DW-100KS

Rutile type flux cored wire for mild steel and 490Mpa high tensile strength steel for low temperature

■ Classification

AWS A.5.20 E71T-9-C-J

■ Features

- 1) Suitable for butt and fillet joint welding in all positions
- 2) Excellent impact value at low temperatures

■ Shielding gas and electrode

100% CO₂ , DC-EP



■ Chemical composition of all-weld metal (%) as per AWS

| | C | Si | Mn | P | S | Ni | |
|----------|-------|-------|-------|-------|-------|-------|--|
| Example | 0.05 | 0.45 | 1.35 | 0.010 | 0.009 | 0.32 | |
| Guaranty | ≤0.12 | ≤0.90 | ≤1.75 | ≤0.03 | ≤0.03 | ≤0.50 | |

■ Mechanical properties of all-weld metal as per AWS

| | 0.2%OS (MPa) | TS (MPa) | EI (%) | IV(J) -40°C | |
|----------|-----------------|-------------|-----------|----------------|--|
| Example | 530 | 591 | 29 | 82 | |
| Guaranty | ≥400 | ≥490 | ≥22 | ≥27 | |

■ Approvals

| ABS | BV | DNV | GL | KR | LR |
|-----|----|-----|----|----|----|
| | | | | | |

■ Packages

| Dia(mm) | Type | Weight(Kg) | Dia(mm) | Type | Weight(Kg) |
|---------|-------|------------|---------|-------|------------|
| 1.2 | Spool | 12.5 | 1.4 | Spool | 12.5 |
| | | 15.0 | | | 15.0 |

■ Recommended welding parameters : DC WIRE(+)

| Welding position | 1.2mm | 1.4mm |
|------------------|-----------|-----------|
| F | 120 ~ 300 | 150 ~ 400 |
| HF | 120 ~ 300 | 150 ~ 350 |
| H | 120 ~ 280 | 150 ~ 320 |
| VU / OH | 120 ~ 250 | 150 ~ 250 |

