

KOBELCO

FAMILIARC™

DW-50

All positional flux cored wire for carbon steel



Code Data

**AWS A5.20 E71T-1CH8,1MH8/ -9CH8, 9MH8
CWB/CSA W48-06 E491T-9-H8,9M-H8**

Outstanding Features

- ◆ Fast freezing slag formula gives DW-50 its excellent weldability not only in horizontal but in vertical and overhead welding.
- ◆ DW-50 can be used with 100%CO₂ or 75%Ar-25%CO₂ shielding gas. It has a wide welding parameter range which makes DW-50 very versatile.
- ◆ Its low fume emission formula creates a clean welding environment at any welding condition.
- ◆ Non-baked wire surface covered with special lubricant creates smooth wire feedability and extended liner life.

Typical chemistry of weld metal and diffusible hydrogen content (100%CO₂ As welded)

C	Si	Mn	P	S	Diffusible hydrogen content (ml/100g)
0.05	0.70	1.27	0.010	0.009	4.7

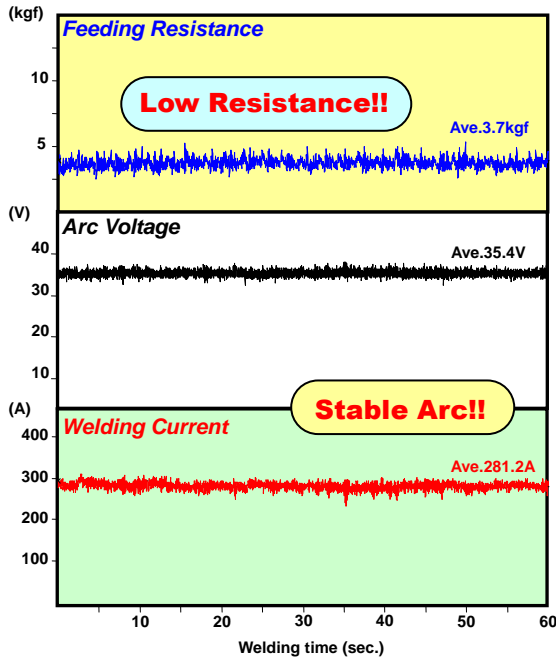
Gas chromatography method (AWS A4.3)

Typical mechanical property of weld metal (100%CO₂ As welded)

0.2%P.S (psi)	T.S (psi)	Elongation (%)	Impact value (ft-lbs)	
			-20°F	0 °F
74,500	86,800	30	58	79

Test method: AWS A5.20, welding parameter: 300A-31V

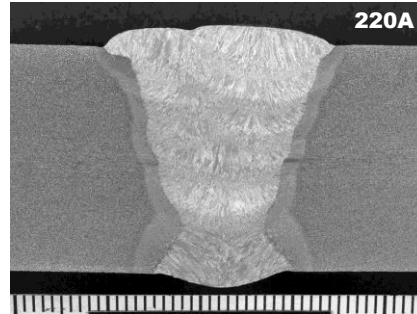
Diameters: 0.045", 0.052", 1/16"
Spool size: 28lbs, 44lbs, Drum: 550lbs



WELDING CONDITIONS

Wire Diameter: 0.045"
Shielding Gas: 100%CO₂ (40CFH)
Length of Cable: 19.5feet

Macrostructure of butt joint(3G)



Recommended welding conditions and deposition rate

Wire size (in.)	Wire feed speed (in./min)	Current (A)	Arc Voltage (V)	Deposition rate (lbs/hr)	Wire stick-out (in.)
0.045	140	120	23-26	4.0	3/4"
	200	160	25-28	6.0	
	290	200	27-30	8.0	
	330	220	27-30	9.0	
	400	250	28-30	10.5	
0.052	120	140	24-27	3.5	3/4"
	175	180	24-27	5.5	
	265	240	26-28	8.5	
	300	260	27-29	10.0	1"
	395	300	29-31	11.5	
1/16	100	180	24-27	4.5	3/4"
	165	240	25-28	7.0	
	190	260	26-29	8.0	1"
	250	300	29-31	10.0	
	300	340	30-32	11.5	

Tables shown are approximate values that will vary with changes in welding conditions.
Voltages shown are for 100%CO₂ shielding gas. For 75%Ar-25%CO₂ use two volts less than shown.
*DC-Electrode positive **Arc voltage is measured at wire feeder.



WARNING: This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to www.P65Warning.ca.gov.

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