

# KOBELCO

## FAMILIARC™

# DW-A55EH

## Rutile-based

## Flux Cord Wire



### Code Data

AWS A5.20 E71T-12MJ H8

ASME SFA-5.20 E71T-12MJ H8

### Outstanding Features

- Meets AWS A5.20 E71T-12MJ. Excellent impact value at low temperature down to -40°F can be obtained.
- Produces weld metal with less than 0.5%Ni. This Ni composition allows this wire to conform to the A-1 composition in QW-440, section IX in the ASME standard.
- Excellent weldability not only in horizontal but also in vertical and overhead welding position with 75-80%Ar - Bal.CO2.
- All position welding can be achieved with good bead appearance, negligible spatter, and easy slag removal.

### Typical chemistry of all weld metal (%) and Diffusible hydrogen content (mL/100g)

	C	Si	Mn	P	S	Ni	[H] <sub>d</sub>
Example	0.05	0.63	1.17	0.010	0.007	0.38	6.9
AWS Spec.	≤0.12	≤0.90	≤1.60	≤0.03	≤0.03	≤0.50	≤8.0

Shielding gas: 75%Ar-25%CO<sub>2</sub>, As welded

### Typical mechanical property of weld metal

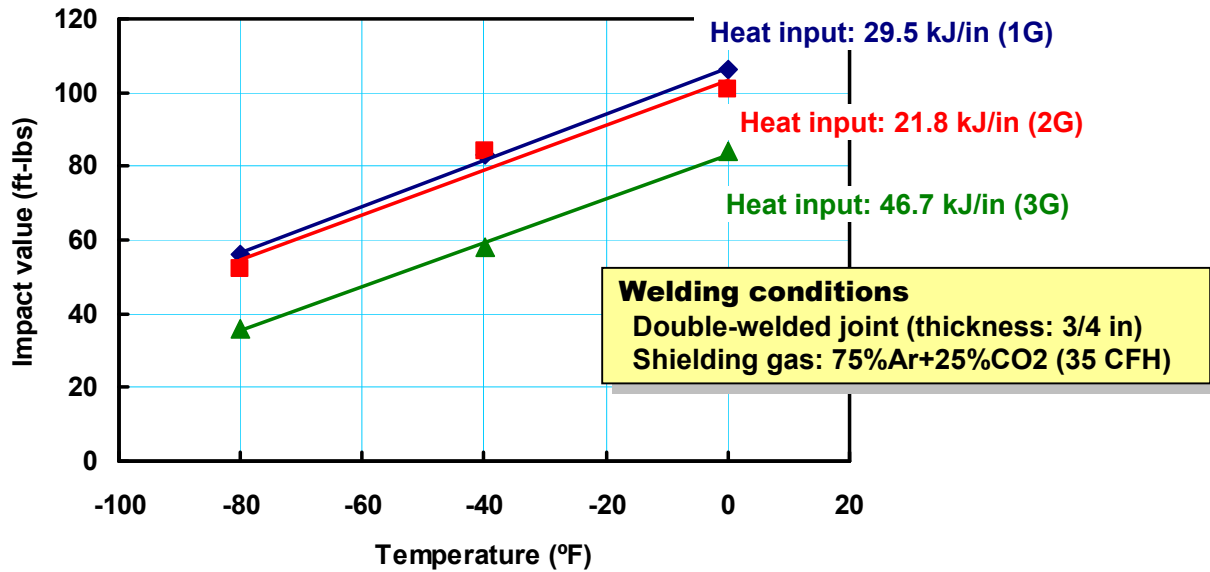
	0.2%P.S (ksi)	T.S (ksi)	Elongation (%)	Impact value (ft-lbf)	
				-50 °F	-40 °F
Example	81	87	29	93	98
AWS Spec.	≥58	70 - 90	≥22	Not specified	≥20

Test method: AWS A5.20, Welding parameter: 250A-29V, Shielding gas: 75%Ar-25%CO<sub>2</sub>, As welded

Diameters: 0.045"

Spool size: 28lbs, 44lbs

**Relationship between temperature and impact value**



**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	21-24	4.0	3/4
	180	140	22-25	5.0	
	200	160	23-26	6.0	
	245	180	24-27	7.0	
	290	200	25-28	8.0	
	330	220	25-28	9.0	
	380	240	26-29	10.0	
	400	250	26-29	10.5	

Tables shown are approximate values that will vary with changes in welding conditions.

\*DC-Electrode positive

\*\*Arc voltage is measured at wire feeder.