

**DW-50**

**FAMILIARC™**

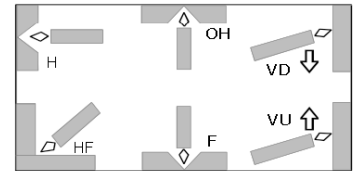
Rutile type flux cored wire for mild steel and 490MPa high tensile strength steel

**Classification:** ASME / AWS A5.20 E71T-1C/1M, -9C/9M  
EN 758 T 42 2 P C/M 1 H5

- Features:**
- Suitable for butt and fillet welding in all positions including vertical down
  - Excellent usability with soft and stable arc, low fume and spatter levels, good bead appearance and easy slag removal

**Shielding gas:** CO<sub>2</sub> or Ar-CO<sub>2</sub> mixture  
**Polarity:** DC-EP

**Welding positions:**



■ **Chemical composition of all-weld metal (%) as per AWS (Shielding gas: CO<sub>2</sub>)**

	C	Si	Mn	P	S
Typical	0.04	0.67	1.29	0.011	0.008
Guaranteed	≤ 0.12	≤ 0.90	≤ 1.75	≤ 0.03	≤ 0.03

■ **Mechanical properties of all-weld metal as per AWS (Shielding gas: CO<sub>2</sub>)**

	YS (MPa)	TS (MPa)	EI (%)	CVN (J)
Typical	510	582	31	-18°C: 108
Guaranteed	≥ 400	≥ 490	≥ 22	-18°C: ≥ 27

■ **Recommended welding parameters**

	1.2mm	1.6mm
Dia.	1.2mm	1.6mm
F	120~300A	180~450A
HF	120~300A	180~400A
H	120~280A	180~400A
VU, OH	120~270A	180~280A
VD	200~300A	250~300A

■ **Approvals**

AB	LR	NV	NK	Others
3SA,3YSA(H5)	3S,3YS(H5)	IIIYMS(H5)	KSW53G(C)	GL, CWB

■ **Packaging**

Dia. (mm)	Type	Weight (kg)
1.2	Spool	15
1.6	Spool	15

Diam.	15 kg Spool
1.2mm	KOBE DW5012
1.6mm	KOBE DW5016

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