

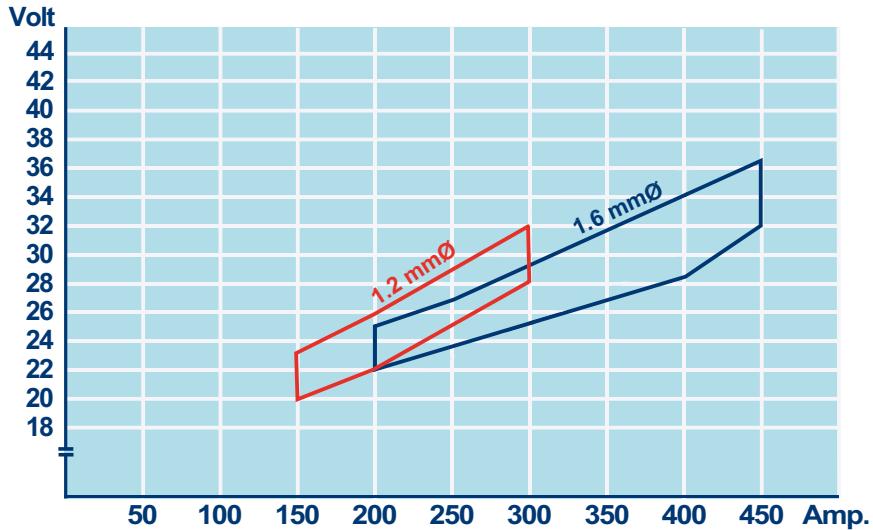
Description and Application

DW-A51B is a fully basic FCW which produces very low hydrogen weld metal of excellent crack resistance.

This wire is particularly suitable for multipass welding of medium to heavy sections where conditions of high restraint exist and where extra low hydrogen levels are necessary.

DW-A51B is also often applied in situations where an ideal joint fit-up can not be achieved, leading to an increased risk of cracking when applying other welding consumables, for example when welding root passes on ceramic backing.

Recommended Parameter Range, for flat position



Chemical Analysis (wt.%)

	C	Si	Mn	P	S	Ni	Cr	Mo	Shielding gas
DW-A51B (=/+)	0.08	0.49	1.43	0.012	0.008	-	-	-	80%Ar-20%CO ₂
DW-A51B (=/-)	0.08	0.46	1.45	0.011	0.008	-	-	-	80%Ar-20%CO ₂

Mechanical Properties

	R _e (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	CV (J) -20°C	CV (J) -40°C	Shielding gas
DW-A51B (=/+)	490	569	29	130	108	80%Ar-20%CO ₂
DW-A51B (=/-)	473	560	31	139	127	80%Ar-20%CO ₂

Welding Positions

DW-A51B
1.2, 1.6mm



Approvals

	LR	DNV	BV	GL	ABS	R.M.R.S.	Others
DW-A51B	3YS	IIYMS	SA3YM	3YS	-	-	TÜV,DB