

DW-100

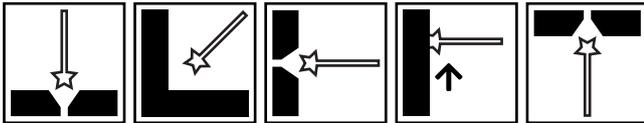
AWS A.20 E71T-1C

Flux cored wire for steel fabrication, heavy equipment and pressure vessels.

GENERAL DESCRIPTION

DW-100 is a rutile type, flux cored wire designed for all-positional welding. Excellent usability with CO₂ shielding gas. Stable arc, less weld spatter, beautiful smooth weld surface, easy to remove slag and low welding fumes. DW-100 provides high welding efficiency due to its high deposition rate and reduced clean up required. Grade 2 Classification Society certified.

WELDING POSITIONS



TYPE OF GAS FLOW

100% CO₂
 20-25 l/min

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

Shielding Gas	C	Si	Mn	P	S	Ni	Cr	Mo	V	Cu
CO ₂	0.05	0.45	1.35	0.01	0.01	0.01	0.02	0.01	0.01	0.02

DIFFUSIBLE HYDROGEN CONTENT: ≤10 ml/100g

TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Yield and Tensile Strengths			Charpy Impact Test V (J)
Yield MPa	Tensile MPa	Elongation %	-20°C
510	570	30	85

GUIDANCE – AMPERE (DC+)

Wire Diameter	1.2 mm	1.4 mm
Ampere	120-300	160-350

PACKAGING INFORMATION

1.2mm x 15kg spool D300

SHIPPING APPROVALS

ABS, DNV, LR, BV

REFERENCE

DW-100, English