

FAMILIARC™ DW-100



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

■ Classification

ASME/AWS A5.20 E71T-1C / KS D7104 YFW-C50DR

■ Features

- 1) High speed welding and all position welding
- 2) Soft and stable arc, less spattering and fume

■ Shielding gas and electrode

100% CO₂ , DC-EP



■ Chemical composition of all-weld metal (%) as per AWS

	C	Si	Mn	P	S
Example	0.05	0.45	1.35	0.013	0.009
Guaranty	≤0.12	≤0.90	≤1.75	≤0.03	≤0.03

■ Mechanical properties of all-weld metal as per AWS

	0.2%OS (MPa)	TS (MPa)	EI (%)	IV(J)	
				0°C	-18°C
Example	510	580	28	110	85
Guaranty	≥400	≥490	≥22	≥47	≥27

■ Approvals

ABS	BV	DNV	GL	KR	LR	NK
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■ Packages

Dia(mm)	Type	Weight(kg)	Dia(mm)	Type	Weight(kg)
1.2	Spool	12.5	1.4	Spool	12.5
		15.0		Pack	200

■ Recommended welding parameters : DC WIRE(+)

Welding position	1.2mm	1.4mm
F	120 ~ 300	150 ~ 400
HF	120 ~ 300	150 ~ 350
VU / OH	120 ~ 260	150 ~ 270
VD	200 ~ 300	220 ~ 300

