Flux Cored Mig Wires | Kobe DW 50 FCW

Key Facts

- KOBE DW-50 is a rutile (titania) type flux cored wire with high operator appeal
- DW-50 delivers a soft and stable arc, low fume and spatter, superb bead appearance and easy slag removal
- Suitable for butt and fillet welding in all positions including vertical-down, due to the fast freezing slag
- Can be used equally as well on both Carbon Dioxide (CO_2) and Argon based (Ar+) shielding gases
- High efficiency with high deposition rates even in the vertical-up and overhead positions
- DW-50 is layer wound and has a non-baked, shiny wire surface, coated with a proprietary lubricant to create smooth wire feed ability which also extends liner life

Description

DW-50 is a user friendly, easy-to-use structural grade flux cored wire, suitable for use with high currents with both CO2 and mixed gases. The sophisticated flux ingredients and sheath (tube) design contribute to reduce fume emissions, to a low 266 mg/min, which greatly improves the working environment.

Classifications, Approvals & Conformances

AWS A5.20: E71T-1/1M & E71T-9/9M
ABS:3YSA H5, LRS: 3YS, and Grade 3 to NV, GL and NK

Recommended Shielding Gas

Argon +18-25%CO_2 or Equivalent
AS 4882-2003: SG-AC-18 or SG-AC-25
ISO-14175-97: M21, M21(1) or M24

Welding Grade Carb on Dioxide CO_2
AS 4882-2003: SG-C
ISO-14175-97: C1

Welding Positions

All positional; flat, horizontal, vertical-up, vertical-down and overhead.

Applications

Kobe DW-50 is an improved impact toughness FCA welding wire suitable for high quality fillet and butt welding of mild and medium strength steel structures, storage tanks, piping, girders & beams as used in the construction, military, building, mining and fabrication industries.

Steel grades commonly welded with DW-50 are; AS3678 (AS 1204) Grades 200, 250, 300, 350, 400 plus LO and L15 Grades

Typical All Weld Metal Analysis With CO2 Shielding

C - Carbon	Mn- Manganese	Si - Silicon	P - Phosphorus
0.050%	1.340%	0.700%	0.008%
S - Sulphur			
0.009%			

Typical All Weld Metal Analysis

C-Carbon	Mn- Manganese	Si - Silicon	Ph - Phosphorus
0.050%	0.830%	1.530%	0.008%
S - Sulphur			
0.009%			

Typical All Weld Metal Mechanical Properties (Argon+25%CO_2):

Yield Strength:	625 MPa
Tensile Strength:	565 MPa
Elongation (5xD):	29%
Impact Strength Charpy-V	120J @ -18^{o}C

Packaging & Ordering Information

Size	Spool Size	Weight	Volts	Amps	P/N
1.2mm	300mm	15kg	25-32	200-280	200265
1.6mm	300mm	15kg	29-36	240-380	200266