

Low Alloy Steel Flux Cored Wire

TRUSTARC™

DW-81B2 AWS A5.29 E81T1-B2C/B2M Diameter: 0.045", 1/16"

C	Mn	Si	P	S	Cr	Mo	YS (ksi)	TS (ksi)	EI (%)
0.06	0.57	0.62	0.008	0.010	1.27	0.50	84.0	96.0	26

Shielding gas: 100%CO₂ or 75-80% Ar / bal. CO₂

Approvals: CWB



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DW-91B3 AWS A5.29 E91T1-B3C/B3M Diameter: 0.045", 1/16"

C	Mn	Si	P	S	Cr	Mo	YS (ksi)	TS (ksi)	EI (%)
0.06	0.60	0.60	0.009	0.012	2.21	0.97	88.0	102.0	26

Shielding gas: 100%CO₂ or 75-80% Ar / bal. CO₂

Approvals: CWB



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DW-A55LSR AWS A5.29 E81T1-Ni1M Diameter: 0.045" *Suitable for PWHT conditions*

C	Mn	Si	P	S	Ni	IV@-76°F (ft-lbf)	YS (ksi)	TS (ksi)	EI (%)
0.05	1.32	0.33	0.009	0.008	0.90	89	74.0	82.7	29

Shielding gas: 75-80% Ar / bal. CO₂

Approvals: ABS, LR, DNV, BV



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DW-A81Ni1 AWS A5.29 E81T1-Ni1MJ Diameter: 0.045"

C	Mn	Si	P	S	Ni	IV@-76°F (ft-lbf)	YS (ksi)	TS (ksi)	EI (%)
0.05	1.26	0.32	0.006	0.006	0.95	105	75.0	84.4	29

Shielding gas: 75-80% Ar / bal. CO₂

Approvals: ABS, LR, DNV, CWB



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DW-A80L AWS A5.29 E111T1-GM H4 Diameter: 0.045" *110 ksi tensile strength*

C	Mn	Si	P	S	Ni	Mo	IV@-76°F (ft-lbf)	YS (ksi)	TS (ksi)	EI (%)
0.07	1.86	0.31	0.007	0.006	2.49	0.16	60	111.0	118.0	21

Shielding gas: 75-80% Ar / bal. CO₂

Approvals: ABS, LR, DNV, GL



Low Alloy Steel Metal Cored Wire

TRUSTARC™

MX-A80L AWS A5.29 E110C-G H4 Diameter: 0.045" *110 ksi tensile strength*

C	Mn	Si	P	S	Ni	Mo	IV@-76°F (ft-lbf)	YS (ksi)	TS (ksi)	EI (%)
0.06	1.87	0.48	0.008	0.010	2.37	0.09	66	104.0	115.0	24

Shielding gas: 75-80% Ar / bal. CO₂

Approvals: -

