KOBELCO

For tensile strength 110ksi Class high strength steel

TRUSTARC™

DW-A80L

Rutile based flux cored wire

AWS A5.29 E111T1-GM H4

TRUSTARC™

MX-A80L

Metal cored wire

AWS A5.28 E110C-G H4

Outstanding Features

- DW-A80L and MX-A80L are designed for welding tensile strength 110ksi class high strength steel that are used in heavy industries such as Offshore, Pipeline, Crane, Construction machinery, etc.
- DW-A80L is a rutile flux cored wire for all positional welding.
- MX-A80L is a metal cored wire for flat and horizontal welding.
- Both these wires can provide excellent mechanical properties and crack resistance.

Typical chemistry of weld metal (80%Ar-20%CO_2)

Wire	C	Si	Mn	P	S	Ni	Mo
DW-A80L	0.07	0.31	1.86	0.007	0.006	2.49	0.16
MX-A80L	0.06	0.48	1.87	0.008	0.010	2.37	0.09

Typical mechanical property of weld metal(80%Ar-20%CO_2)

Wire	0.2%P.S (ksi)	T.S (ksi)	Elongation (%)	Impact value (ft-lbf)	
				-76 °F	-40 °F
DW-A80L	111	118	21	60	83
MX-A80L	104	115	24	66	107

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TRUSTARC™ **DW-A80L** AWS A5.29 E111T1-GMH4

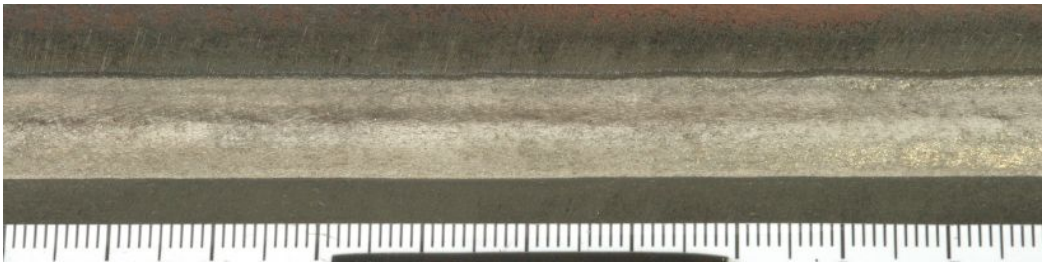
TRUSTARC™ **MX-A80L** AWS A5.28 E110C-G H4

Typical diffusible hydrogen content in deposited metal (80%Ar-20%CO_2)

Wire	Diffusible hydrogen content [a] (ml/100g)				
					Average
DW-A80L	2.6	2.9	2.6	2.6	2.7
MX-A80L	1.3	1.2	1.4	1.3	1.3

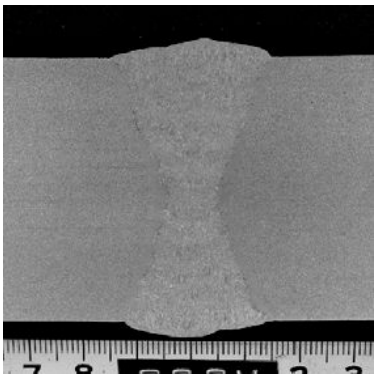
a. Gas chromatography method (AWS A4.3)

Bead appearance and macro cross sections

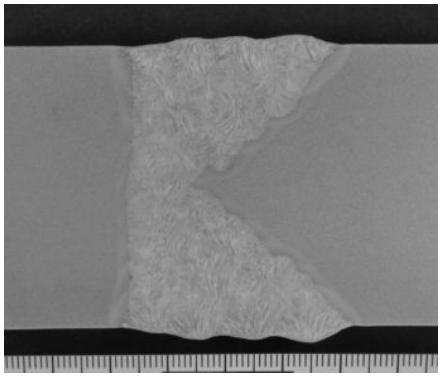


MX-A80L

Horizontal fillet welding
0.045" 260A-31V-18IPM
80%Ar-20%CO_2



Position: 3G, Wall thickness: 50mm,
Heat input: 5.3kJ/inch



Position: 1G, Wall thickness: 50mm,
Heat input: 4.6kJ/inch

Diameters: 0.045"
Spool size: 28lbs

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