



**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<sub>2</sub>)**

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<sub>2</sub>)**

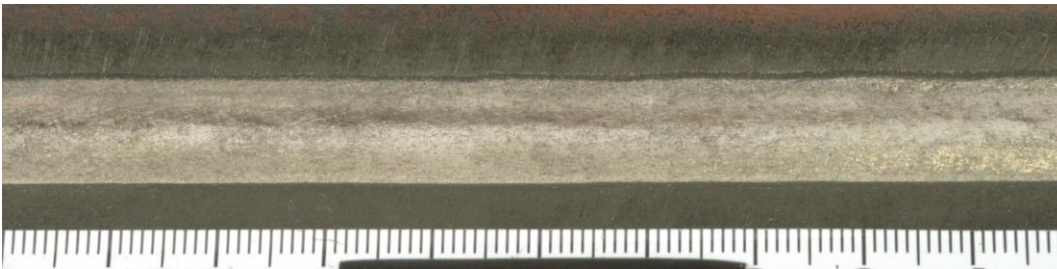
Wire	0.2%P.S (ksi)	T.S (ksi)	Elongation (%)	Impact value (ft-lbf)	
				-76 °F	-40 °F
DW-A80L	111	118	21	60	66
MX-A80L	104	115	24	89	107

**Typical diffusible hydrogen content in deposited metal (80%Ar-20%CO<sub>2</sub>)**

Wire	Diffusible hydrogen content <sup>a</sup> (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

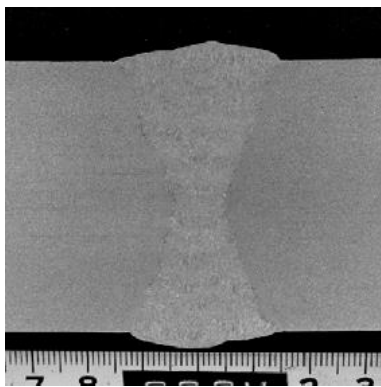
a. Gas chromatography method (AWS A4.3)

## Bead appearance and macro cross sections

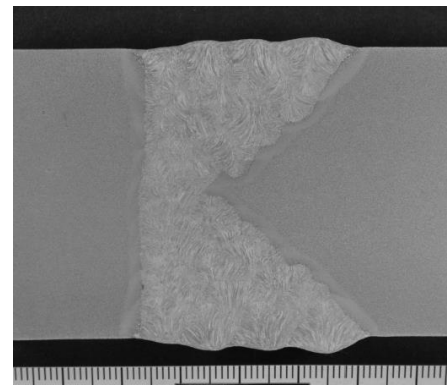


### MX-A80L

Horizontal fillet welding  
0.045" 260A-31V-18IPM  
80%Ar-20%CO<sub>2</sub>



**DW-A80L 0.045"**  
Position: 3G, Wall thickness: 50mm,  
Heat input: 5.3kJ/inch



**MX-A80L 0.045"**  
Position: 1G, Wall thickness: 50mm,  
Heat input: 4.6kJ/inch

**Diameters: 0.045"**  
**Spool size: 28lbs**



**WARNING:** This product can expose you to chemicals including Nickel and Titanium Dioxide, which are known to the State of California to cause cancer, and Chromium, which is known to the State of California to cause cancer and birth defects or other reproductive harm. For more information go to [www.P65Warnings.ca.gov](http://www.P65Warnings.ca.gov).

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