

Self shielded flux-cored wire for all position with higher impact toughness

AWS A5.20 E71T-8 H16

EN ISO 17632-B T49 3 T8-1 NO A



### Features and typical fields of application

- Familiarc™ OW-S50P is a self shielded mild steel flux-cored wire for all position welding in single pass and multi pass welding not requiring shielding gas capable with low temperature impact toughness down to -20F.
- Its porosity resistance formula allows to weld even under the wind of 9m/sec (17.5 knots, fresh breeze) without causing blow holes with properly controlled welding parameter and wire stick out.
- Its flat bead profile with very stable arc minimizing spatter generation formula applying to DCEN polarity make it the best choice for on-site welding like structural fabrication, scaffolding, machinery structures, or tank fabrications.

### Typical result of weld metal test per AWS A5.20

C	Si	Mn	P	S	Al	0.2% PS (ksi)	TS (ksi)	EL (%)	CVN (ft-Lbs)
									-20F°
0.14	0.20	0.84	0.015	0.002	0.65	64	81	27	77

### Diffusible Hydrogen Content as per AWS A4.3

OW-S50P	9.0 mL/100g
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### Available Sizes

Wire Dia.	5/64" (2.0mm)
Package	33Lbs (15kg) spool, 50Lbs (22.7kg) Coil

#### DISCLAIMER

- Information in this material, such as chemical compositions and mechanical properties, is typical or an example for explaining the features and performances of our products, and it does not mean guarantee unless otherwise it is specified.
- Information contained herein is subject to change without notice. Please kindly contact Kobelco for latest information.



**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).

**KOBELCO WELDING OF AMERICA INC.**



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## Recommendation for Use

### Welding Operation Range

- Polarity: DCEN
- Wire Stick Out: 1" to 1 1/2"
- 1F/1G 200-350A
- 2F 200-350A
- 2G 200-320A
- 3G Uphill or 4G 200-270A

### Cold Cracking Prevention

Preheating and Interpass temperature control is recommended to prevent cold cracking especially when using this product to weld thick plates over 1". The guide line of the minimum temperature to control for the cold crack prevention is 250 F.

### Blowhole Free Welding Parameter Window

Too long arc may cause blowholes. The guideline of welding current and arc voltage is shown in the figure 1 below.

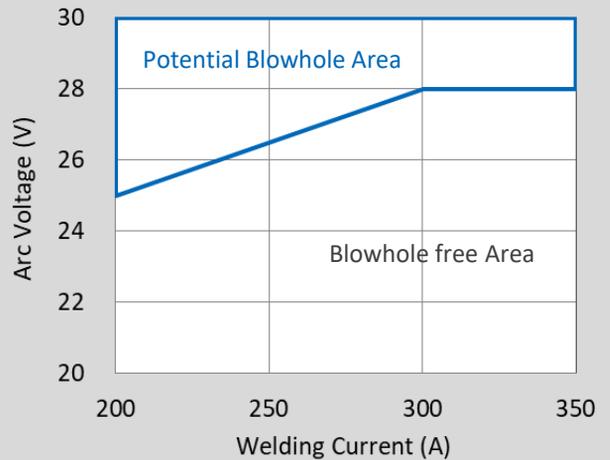


Figure 1 Welding current-Voltage Window which may cause blow holes

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