

Rutile flux cored wire for low temperature application
AWS A5.20 E71T-12CJ H8



Features and Typical fields of application

- DW-50EA is a *Low Hardness (HB<200)* 70ksi class rutile flux cored wire for mild steel and low temperature service steel welding with straight CO₂ gas.
- Designed for welding of **Liquified Ammonia tanks**; this wire meets general NACE requirements (e.g., HB<200 at the cap pass), making it superior choice for oil and gas industry.
- Excellent impact toughness value down to -50°F.

Mechanical properties of all-weld metal per AWS A5.20

Shielding Gas	0.2%PS (ksi)	TS (ksi)	EI (%)	CVN (ft-lbs) at -50°F	HB*
100%CO ₂	63	75	34	80	189

Brinell Hardness of cap pass (1/16" below the surface of weld metal)

Chemical composition of all-weld metal per AWS A5.20 (%)

Shielding Gas	C	Si	Mn	P	S	Ni
100%CO ₂	0.07	0.21	1.16	0.008	0.006	0.43

Diffusible Hydrogen Content per AWS A4.3

Approvals

3.6 mL/100g

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Available Products

Wire Dia.	0.045"	Package	44 lbs spool
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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.

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