

Description and Application

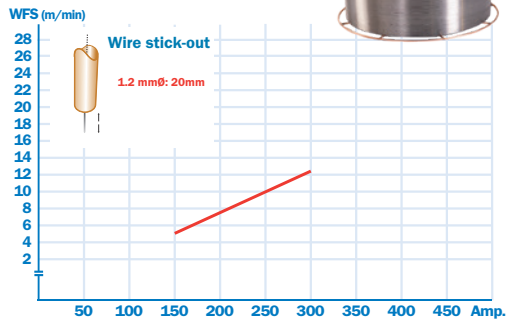
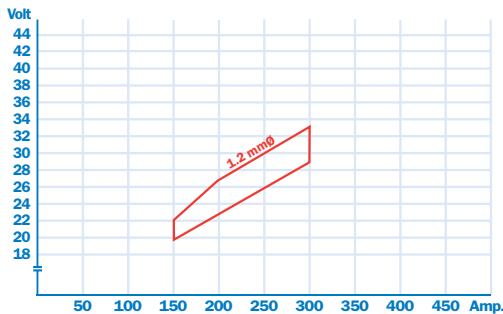
DW-A65Ni1 is especially designed to meet the demands of On-Shore and Off-Shore pipelines. This wire is used for the welding of high tensile strength steels like X65, X70, including matching and/or, overmatch requirement from the nominal yield levels of these materials.

DW-A65Ni1 produces a weld metal containing max 1.0%Ni, something that also makes this wire comply with the NACE requirements for sour gas service.

DW-A65Ni1 is a rutile flux cored wire, ensuring good operability and weldability on fixed pipes in vertical up PH (5G) position.



Recommended Parameter Range, for flat position



Typical Chemical Analysis (wt. %)

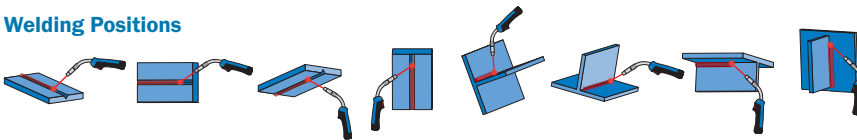
C	Si	Mn	P	S	Ni	Cr	Mo
0.05	0.33	1.51	0.009	0.008	0.95	-	0.16

Typical Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	CV(J)-50°C
	611	670	23	84
Guaranty	min.550	640~760	min.18	min.47

Example of Diffusible hydrogen content: 3.3 [ml/100g]

Welding Positions



Approvals

LR	DNV GL	BV	ABS	R.M.R.S	Others
4Y50S H5	IVY50MS (H5)	-	-	-	-