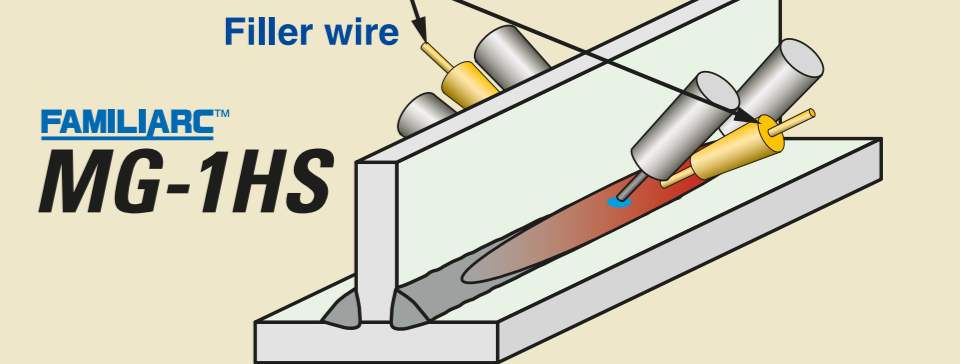


Welding Consumables for Shipbuilding



FAMILIARC™ DW-A50 **FAMILIARC™ DW-50**

TRIFARC™ Triple Electrodes Tandem One Pool



FAMILIARC™ MX-200HS



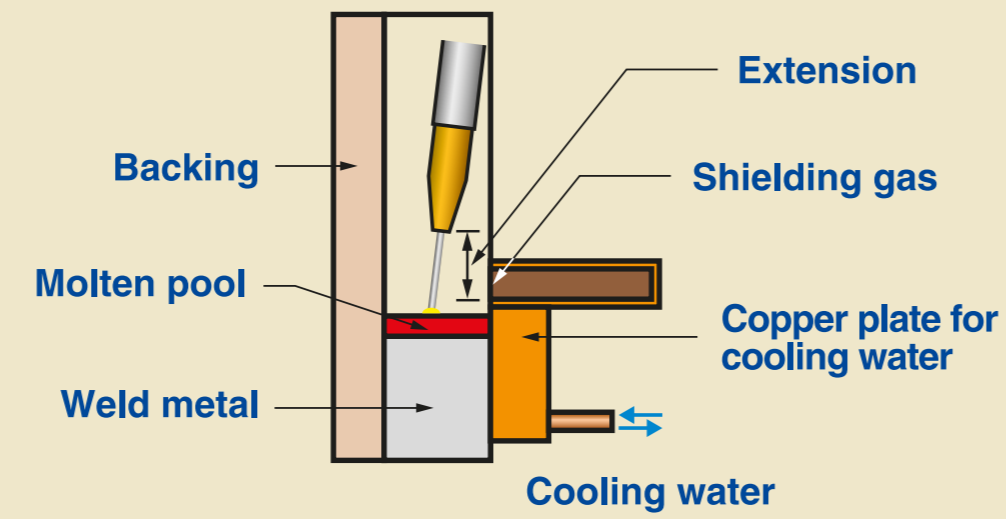
Example of bead appearance and macro structure

Example of welding condition
 L pole : 560A-38V
 T pole : 440A-36V
 Filler wire : **FAMILIARC™ MG-1HS**
 Polarity DCEN, Current 80A
 Travel speed : 2,000mm/min

SEGARC™

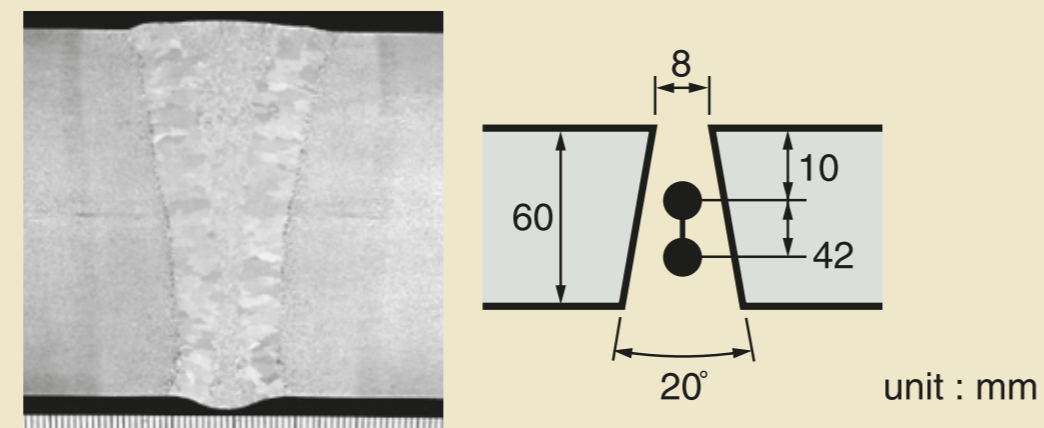


FAMILIARC™ DW-S1LG



Example of welding condition

Current (A)	Voltage (V)	Travel speed (mm/min)	Heat input (kJ/mm)
400	43	26	39.7



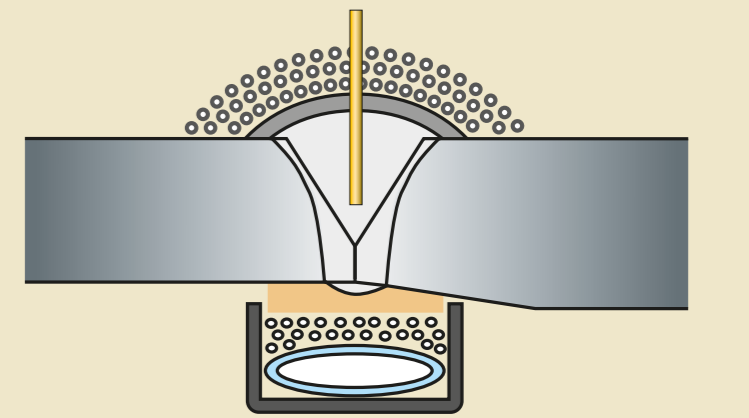
Example of welding in shipbuilding

FCW for all position welding	FAMILIARC™ DW-50, DW-A50, DW-100V
FCW for fillet welding	FAMILIARC™ MX-200E, MX-200H, MX-200HS
FCW for electrogas welding	FAMILIARC™ DW-S1LG, DW-S43G
Welding consumables for SAW	FAMILIARC™ PF-155E/US-36/PF-150R, PF-155E/US-36/RF-1

FCB™ / RF™



FAMILIARC™ PF-155E/US-36/RF-1



Example of welding condition
 Plate thickness 20mm
 L pole : 1400A-26V
 T1 pole : 1000A-40V
 T2 pole : 1100A-46V
 Travel speed : 800mm/min

by courtesy of Namura Shipbuilding Co., Ltd.