

TWE-715

AWS A5.20 E71T-5C
EN ISO 17632-A-T 46 3 B C1 1 H10

Characteristics and Applications:

TWE-715 is an all-position flux-cored wire designed to be used with CO₂ gas for 490N/mm² grade high tensile steel. Its low temperature impact toughness is better than E71T-1(AWS A5.20). The typical applications of TWE-715 are constructional steel, machinery and shipbuilding.

Notes on usage:

1. DC(+) polarity is recommended.
2. Use CO₂ as shielding gas.
3. Keep inter-pass temperature under 150°C when you are in multiple-pass welding.
4. Keep the product dry, while it is stored or delivered.

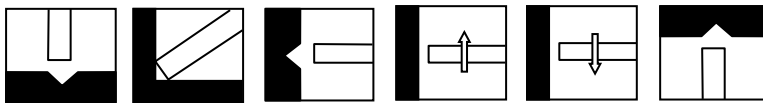
Typical chemical composition of weld metal (wt%) :

	C	Mn	Si	P	S
AWS	≤ 0.12	≤ 1.75	≤ 0.90	≤ 0.03	≤ 0.03
EN ISO	-	≤ 2.0	-	-	-
Typical value	0.05	1.30	0.45	0.015	0.007

Typical mechanical properties of weld metal :

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -30(-20°F)
AWS	≥ 390(58)	490-670(70-95)	≥ 22	≥ 27(20)
EN ISO	≥ 460(67)	530-680(77-99)	≥ 20	≥ 47(35)
Typical value	493(72)	562(82)	30	65(48)

Welding position:



Sizes and recommended operating range (DC < + >):
Stick out:15-25(mm), flow rate:20-25(l/min):

Position	Diameter (mm)	1.2	1.6
	F		130A~300A / 24V~36V
HF		130A~300A / 24V~36V	160A~340A / 24V~38V
H		130A~300A / 24V~36V	160A~340A / 24V~38V
VU, OH		130A~300A / 24V~36V	160A~340A / 24V~38V
VD		230A~280A / 28V~33V	250A~320A / 28V~32V

* The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TienTai Electrode Co., Ltd. expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.