TWE-711M

AWS A5.20 E71T-1M
EN ISO 17632-A-T 46 3 P M21 1 H10
JIS Z 3313 T 49J 0 T1-1 M A-U

Characteristics and Applications:

TWE-711M is a flux-cored wire designed to be used with Ar/ CO_2 gas. It's available for all-position welding with both single and multiple pass welds on mild and 490N/mm^2 high tensile steels. It features good impact properties, less fume, stable arc, easy slag removable and excellent X-Ray inspection. Typical applications include shipbuilding, storage vessels, structural fabrication, machinery and piping etc.

Notes on usage:

1. Use DC(+) polarity.
2. Use 75~80%Ar + 25~20%CO_2 as shielding gas.
3. Keep the product dry, while it is stored or delivered.

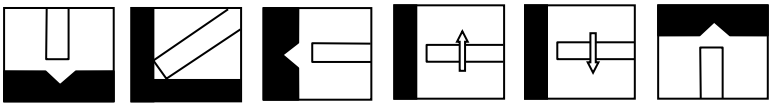
Typical chemical composition of weld metal (wt%) :

	C	Mn	Si	P	S
AWS	≦0.12	≦1.75	≦0.90	≦0.03	≦0.03
EN ISO	-	≦2.0	-	-	-
Typical value	0.04	1.30	0.30	0.013	0.007

Typical mechanical properties of weld metal :

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-1bf) -30°C (-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	567(82)	608(88)	29	66(49)

Welding position:



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

Position \ Diameter (mm)	1.2	1.6
F, HF	140A~300A / 22V~34V	200A~350A / 24V~32V
H	140A~280A / 22V~32V	200A~320A / 24V~31V
VU, OH	140A~220A / 22V~26V	160A~220A / 22V~26V
VD	230A~280A / 28V~32V	240A~300A / 24V~31V

FLUX CORED WIRES

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