

# TM-77

AWS A5.18 E70C-6M  
EN ISO 17632-A-T 46 4 M M21 3 H5  
JIS Z 3313 T 49 4 T15-0 MA-U

## Characteristics and Applications:

TM-77 is a gas-shielded metal-cored wire that features smooth spray arc, low slag volume, low spatter, low diffusible hydrogen low fume emission and excellent low temperature impact toughness down to -40°C. It welds with a wider penetration profile and higher deposition efficiency than solid wire.

Multi-layer welding can be performed without removing slag. It is suitable for steel structures, storage vessels and multi-layer welding on heavy plate thickness.

## Notes on usage:

1. Use DC(+) polarity.
2. Ar-CO<sub>2</sub> mixture. 75%~80%Ar + 25%~20%CO<sub>2</sub>.
3. Inter-pass temperature should be under 150°C while 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
0.04	1.45	0.54	0.010	0.008

## Typical mechanical properties of weld metal:

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -40°C(-40°F)
480(70)	550(80)	26	65(48)

## Welding position:



## Sizes and recommended current range ( DC <+> ):

Stick out: 15-25 (mm) , flow rate: 20-25 (l/min)

Diameter (mm)	1.2	1.4	1.6
Parameters			
F, H	240A-320A/26V-34V	260A-340A/27V-34V	270A-360A/ 28V-35V

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