TWE-704-O

AWS A5.20 E70T-4
EN ISO 17632-A-T 46 Z W N 3

Characteristics and Applications:

TWE-704-O is a self-shielded flux-cored wire, it is designed for on site general fabrication and structural work requiring, good slag release and friendly to manage variant weld joints by longer sticking out. The welding for heavy machinery, large construction components is appropriate, also stiffens in large building. It is suitable for flat, horizontal and downhill positions, also it can be applied to build up the worn parts.

Notes on usage:

1. DC(+) polarity is recommended.
2. TM-70C or TWE-711 are recommended when impact toughness of weld metal is essential.
3. Keep the product dry, while it is stored or delivered.

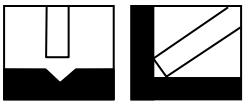
Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Al
0.25	0.45	0.30	0.012	0.004	1.40

Typical mechanical properties of weld metal:

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %
450(62)	600(87)	25

Welding position:



Sizes and recommended parameter range (DC＜+＞) :
Stick out: 40-60 (mm)

Position \ Diameter (mm)	2.4	2.8
F, HF	250A-400A/26V-34V	280A-450A/27V-36V

FLUX CORED WIRES

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