

TWE-715

AWS A5.20 E71T-5C
EN ISO 17632-A-T 46 3 P 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.

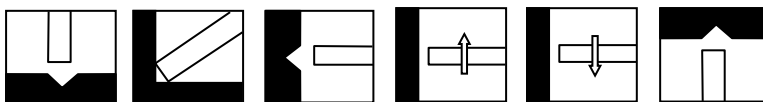
Typical chemical composition of weld metal (wt%) :

	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

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