# 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.

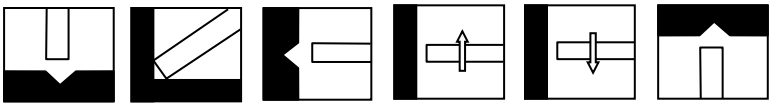
## Typical chemical composition of weld metal (wt%)：

| | 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 |
|---|---|
| F, HF | 140A~300A / 22V~36V |
| H | 140A~280A / 22V~33V |
| VU, OH | 140A~220A / 22V~28V |
| VD | 230A~280A / 28V~33V |





TIENTAI
AN ILLINOIS TOOL WORKS COMPANY
No.6, Kaifa 4th Rd., Rende Dist., Tainan City 717, Taiwan
TEL:886-6-2663721 /FAX:886-6-2664301
E-mail:twtrad@itwweld.com
http://www.tientai.com