TWE-711

AWS A5.20 E71T-1C
EN ISO 17632-A-T 46 2 P C1 1 H10
JIS Z 3313 T 49 2 T1-1 C A-U

Characteristics and Applications:

TWE-711 is a flux-cored wire designed to be used with CO_2 gas and 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, good slag release 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 CO_2 (more than 99.8% purity) as shielding gas.
3. Keep the product dry, while it is stored or delivered.

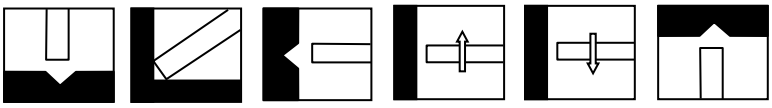
Typical chemical composition of weld metal (wt%)：

	C	Mn	Si	P	S
AWS	≦0.12	≦1.75	≦0.90	≦0.03	≦0.03
EN ISO	-	≦2.0	-	-	-
Typical value	0.05	1.30	0.45	0.015	0.008

Typical mechanical properties of weld metal：

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J(ft-lbf)	
				-20°C (0°F)	-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	540(78)	590(86)	30	100(74)	70(52)

Welding position:



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

Position \ Diameter (mm)	1.2	1.4	1.6
F, HF	140A~300A / 23V~36V	150A~350A / 22V~34V	200A~400A / 28V~42V
H	140A~280A / 22V~33V	150A~280A / 22V~32V	200A~400A / 28V~42V
VU, OH	140A~220A / 22V~28V	150A~230A / 22V~28V	160A~280A / 22V~28V
VD	230A~280A / 28V~33V	250A~300A / 28V~32V	250A~320A / 28V~32V

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