

TWE-707-O

AWS A5.20 E70T-7
EN ISO 17632-A-T 42 Z W N 3

Characteristics and Applications:

TWE-707-O is a self-shielded flux cored wire designed for high penetration welding. It is suitable for flat, horizontal and downhill positions on DCEN polarity. Excellent performance on X-ray inspection, and desulfuration reduces cracking in welding thick plates, constrained joints and medium-carbon steel. The typical applications of TWE-707-O are general fabrication and structural weldment where high deposition with good penetration and / or fast travel speed is needed. Available positions are flat weld, horizontal weld and vertical down ones of welding for fillet weld and lap joint.

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.

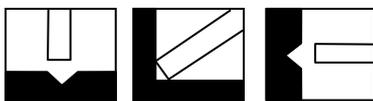
Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S	Al
AWS	≤ 0.30	≤ 1.75	≤ 0.60	≤ 0.03	≤ 0.03	≤ 1.8
EN ISO	-	≤ 2.0	-	-	-	≤ 2.0
Typical value	0.25	0.40	0.12	0.010	0.005	1.50

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %
AWS	≥ 390(58)	490-670(70-95)	≥ 22
EN ISO	≥ 420(61)	500-640(73-93)	≥ 20
Typical value	453(66)	600(87)	25

Welding position:



Sizes and recommended parameter range (DC <->):

Stick out: 40-60 (mm)

Diameter (mm)	1.6	2.0	2.4	2.8
Position				
F, HF	240A-280A/ 24V-28V	250A-350A/ 24V-32V	250A-400A/ 26V-34V	280A-450A/ 28V-36V

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