

TWE-711

JIS Z 3313 YFW -C50DR
AWS A5.20 E71T-1C
EN758 T 42 2 P C 1 H10

Characteristics and Applications:

TWE-711 is a flux-cored wire designed to be used with CO₂ gas and it's available for all-position welding with both single and multiple pass welds on mild and 490N/mm² high tensile steels. It provides 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 CO₂ (more than 99.8% purity) as shielding gas and flow rate should be around 20~25 l/min.
3. Keep dry during delivery and storage.

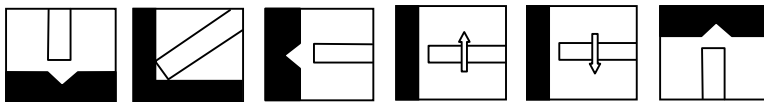
Typical chemical composition of weld metal (wt%) : (CO₂)

C	Mn	Si	P	S
0.05	1.45	0.55	0.015	0.008

Typical mechanical properties of weld metal : (CO₂)

YS (MPa)	TS (MPa)	EL %	CVN -20°C J
530	580	29	100

Welding position



Sizes and recommended current range (DC <+>)

Stick out:15-25(mm),flow rate:15-25(L/mm)

Diameter (mm)	φ 1.2mm	φ 1.4mm	φ 1.6mm
Parameters			
F	140-300	150-350	200-400
HF	140-300	150-350	200-400
H	140-280	150-280	200-280
VU, OH	140-220	150-230	160-230
VD	230-280	250-300	250-320

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