

TWE-715

JIS Z 3313 YFW-C502R/A502R
AWS A5.20 E71T-5C/5M
EN758 T 42 3 P C/M1

Characteristics and Applications:

TWE-715 is an all-position flux-cored wire designed to be used with CO₂ or Ar/ CO₂ gas mixture 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. Both pure CO₂ shielding gas is commonly used and better weldability can be achieved while using 75~80% Argon+20~25% CO₂ shielding gas.
3. Keep inter-pass temperature under 150°C whiling in multiple-pass welding.

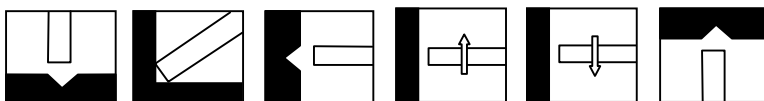
Typical chemical composition of weld metal (wt%) : (CO₂)

| C | Mn | Si | P | S |
|------|------|------|-------|-------|
| 0.05 | 1.45 | 0.50 | 0.015 | 0.007 |

Typical mechanical properties of weld metal : (CO₂)

| YS (MPa) | TS (MPa) | EL % | CVN -29°C J |
|----------|----------|------|-------------|
| 510 | 570 | 29 | 65 |

Welding position



Sizes and recommended current range (DC <+>)

Stick out:15-25(mm),flow rate:20-25(L/mm)

| Diameter (mm) | φ 1.2mm | φ 1.6mm |
|------------------|---------|---------|
| Parameters | | |
| Voltage(Volt) | 24-36 | 24-38 |
| Current(Amp) | 130-300 | 160-340 |
| Stick out(mm) | 15-25 | 15-25 |
| Flow rate(l/min) | 20-25 | 20-25 |

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