

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 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 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 CO₂ (more than 99.8% purity) as shielding gas.
3. Keep the product dry, while it is stored or delivered.

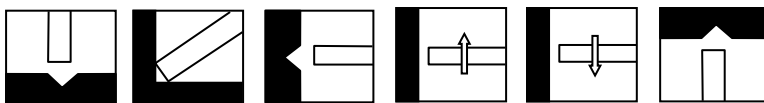
Typical chemical composition of weld metal (wt%) :

C	Mn	Si	P	S
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)
540(78)	590(86)	30	100(74)	70(52)

Welding position:



Sizes and recommended parameter 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
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

* The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and TienTai Electrode Co., Ltd. expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.