

Characteristics and Applications:

ArcStar 711NiM is a gas-shielded flux cored wire designed for mild steel and 490N/mm² high tensile steel. It is suitable for all position welding. It provides stable arc, less spatter, easy slag removable, and excellent X-Ray inspection. It provides good low-temperature impact value due to 0.4%Ni in weld metal. The typical applications include shipbuilding, vessels, piping etc.

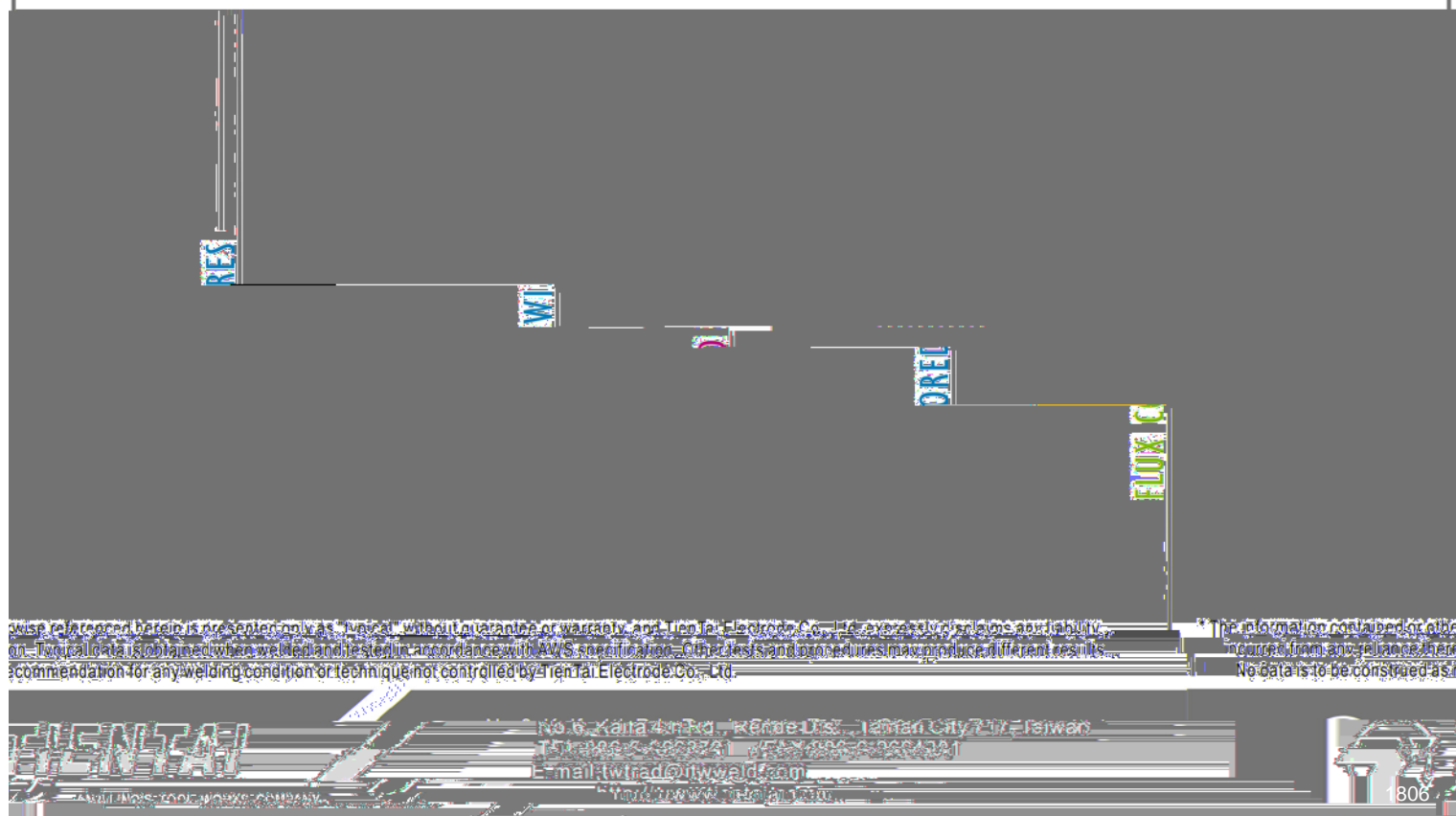
Notes on usage:

1. Use (DC+) polarity.
2. Use 80%Ar + 20%CO₂, 20~25 l/min shielding gas.
3. To get desired impact value, you must control welding heat input, as excessive heat input would decrease notch toughness.
4. Keep the product dry, while it is stored or delivered.

Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S	Ni
0.04	1.31	0.44	0.018	0.007	0.45

Typical mechanical properties of weld metal



The image shows a large, dark, low-contrast photograph of an industrial structure, likely a ship's hull or a large vessel. The structure is composed of various components, including what appears to be a large cylindrical tank or section. There are several labels and markings visible, including a blue 'WELD' label and a green 'FLUX C' label. The overall appearance is that of a technical drawing or a photograph of a large-scale industrial project.

The information contained or otherwise referred herein is presented only as "typical" without guarantee or warranty, and Tientai Electrode Co., Ltd. accepts no responsibility for any loss or damage incurred from any use of the information here. No data is to be construed as a recommendation for any welding condition or technique not controlled by Tientai Electrode Co., Ltd.

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