

## Characteristics and Applications:

ArcStar 711NiM is a gas-shielded flux cored wire designed for mild steel and 490N/mm<sup>2</sup> 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%CO<sub>2</sub>, 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



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**TIENTAI**  
TIENTAI ELECTRODE CO., LTD.  
No. 16, Kaila 4th Rd., Kailuo Dist., Tainan City 717, Taiwan  
Tel: 886-6-6666341 Fax: 886-6-6666341  
E-mail: twtrade@twsteel.com  
http://www.tientai.com.tw

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