

TWE-711

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.

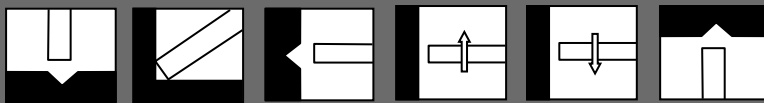
Typical chemical composition of weld metal (wt%)

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 °)	-30°C (-20 °)
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~38V	200A~400A / 24V~42V
H	140A~280A / 22V~33V	150A~280A / 22V~32V	200A~280A / 24V~30V
VU, OH	140A~220A / 22V~28V	150A~230A / 22V~28V	160A~230A / 22V~28V
VD	230A~280A / 28V~33V	250A~300A / 28V~34V	250A~320A / 28V~32V

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