

# TWE-711M

AWS A5.20 E71T-1M  
 EN ISO 17632-A-T 46 3 P M21 1 H10  
 JIS Z 3313 T 49J 0 T1-1 MA-U

## Characteristics and Applications:

TWE-711M is a flux-cored wire designed to be used with Ar/ CO<sub>2</sub> gas. It's available for all-position welding with both single and multiple pass welds on mild and 490N/mm<sup>2</sup> high tensile steels. It features good impact properties, less fume, stable arc, easy slag removable 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 80%Ar+20%CO<sub>2</sub> as shielding gas.
3. Keep the product dry, while it is stored or delivered.

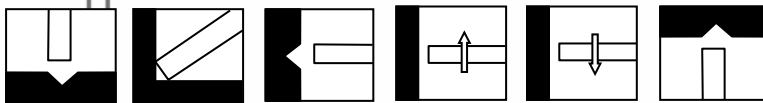
## Typical chemical composition of weld metal (wt%) :

0.04                      1.30                      0.30                      0.013                      0.007

## Typical mechanical properties of weld metal :

567(82)	608(88)	29	66(49)
---------	---------	----	--------

## Welding position:



## Sizes and recommended current range ( DC<+>):

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

Parameters	Diameter (mm)	1.2
	F	
HF		140A~300A / 22V~36V
H		140A~280A / 22V~33V
VU, OH		140A~220A / 22V~28V
VD		230A~280A / 28V~33V

Information referenced herein is presented only as "typical" without guarantee or warranty, and TienTai Electrode Co., Ltd. expressly disclaims any liability. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No recommendation for any welding condition or technique not controlled by TienTai Electrode Co., Ltd.

The information contained or other incurred from any reliance thereon. No data is to be construed as re

