

# TWE-715M

AWS A5.20 E71T-5M  
EN ISO 17632-A-T 46 3 P M 1 H10

## Characteristics and Applications:

TWE-715M is an all-position flux-cored wire designed to be used with Ar/ CO<sub>2</sub> gas mixture for 490N/mm<sup>2</sup> grade high tensile steel. Its low temperature impact toughness is better than E71T-1M(AWS A5.20). The typical applications of TWE-715M are constructional steel, machinery and shipbuilding.

## Notes on usage:

1. DC(+) polarity is recommended.
2. Use 75~80%Ar+25~20%CO<sub>2</sub> as shielding gas.
3. Keep inter-pass temperature under you aer 150 whre in multiple-pass welding.
4. Keep the product dry, while it is stored or delivered.

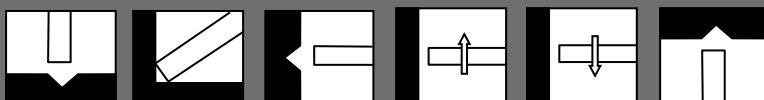
## Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S
0.04	1.35	0.30	0.013	0.007

## Typical mechanical properties of weld metal

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -30°C (-20 )
564(82)	607(88)	26	75(55)

## Welding position:



Sizes and recommended current range ( DC + ):

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

Diameter (mm)	1.2
Parameters	
F, HF, VU, OH, VD, H	140A-300A/22V-33V

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AWS specification. Other tests and procedures may produce different results.  
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The information contained or otherwise referenced herein is presented only as "typical" without any guarantee  
incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with  
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