

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/ CO₂ gas mixture for 490N/mm² 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%CO₂ 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.

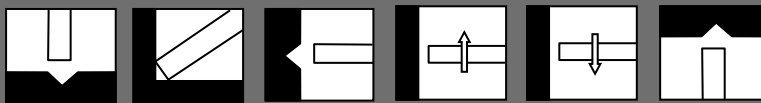
Typical chemical composition of weld metal (wt%)

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):

Parameters	Diameter (mm)	1.2
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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WONKATZTHRD - ROND5 DAV - PANDR CITY 7-12 - TAIWAN
TEL: +886-2-2611-0620
E-mail: tw@ttd.com.tw

