

TWE-711M

JIS Z 3313 YFW -A50DR
AWS A5.20 E71T-1M
EN758 T 42 2 P M 1 H10

Characteristics and Applications:

TWE-711M is a flux-cored wire designed to be used with Ar/ CO₂ gas. It's available for all-position welding with both single and multiple pass welds on mild and 490N/mm² high tensile steels. It provides 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 75~85%Ar+25~15%CO₂ as shielding gas.
3. Keep dry during handling and storage.

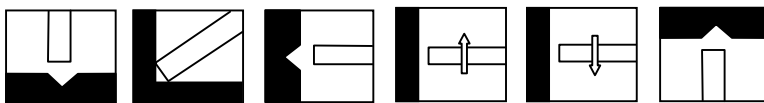
Typical chemical composition of weld metal (wt%) : (80%Ar+20%CO₂)

C	Mn	Si	P	S
0.05	1.25	0.45	0.015	0.007

Typical mechanical properties of weld metal : (80%Ar+20%CO₂)

YS (MPa)	TS (MPa)	EL %	CVN -20°C J
540	590	28	95

Welding position



Sizes and recommended current range (DC <+>)

Diameter (mm)	φ 1.2mm	φ 1.4mm	φ 1.6mm
Parameters			
Voltage(Volt)	22-35	23-35	25-36
Current(Amp)	140-320	150-350	200-380
Stick out(mm)	15-25	15-25	15-25
Flow rate(l/min)	15-25	15-25	15-25

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