

TWE-715

JIS Z 3313 YFW-C502R/A502R
AWS A5.20 E71T-5C/5M
EN758 T 42 3 P C/M1

Characteristics and Applications:

TWE-715 is an all-position flux-cored wire designed to be used with CO₂ or Ar/ CO₂ gas mixture for 490N/mm² grade high tensile steel. Its low temperature impact toughness is better than E71T-1(AWS A5.20). The typical applications of TWE-715 are constructional steel, machinery and shipbuilding.

Notes on Usage:

1. DC(+) polarity is recommended.
2. Both pure CO₂ shielding gas is commonly used and better weldability can be achieved while using 75~80% Argon+20~25% CO₂ shielding gas.
3. Keep inter-pass temperature under 150°C whiling in multiple-pass welding.

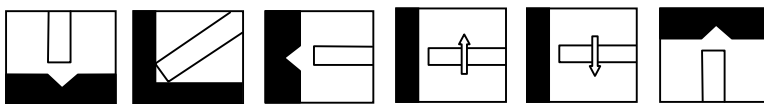
Typical chemical composition of weld metal (wt%) : (CO₂)

C	Mn	Si	P	S
0.05	1.45	0.50	0.015	0.007

Typical mechanical properties of weld metal : (CO₂)

YS (MPa)	TS (MPa)	EL %	CVN -29°C J
510	570	29	65

Welding position



Sizes and recommended current range (DC <+>)

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

Diameter (mm)	φ 1.2mm	φ 1.6mm
Parameters		
Voltage(Volt)	24-36	24-38
Current(Amp)	130-300	160-340
Stick out(mm)	15-25	15-25
Flow rate(l/min)	20-25	20-25

*The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Tien Tai Electrode Co., Ltd. expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with AWS specification. Other tests and procedures may produce different results. No data is to be construed as recommendation for any welding condition or technique not controlled by Tien Tai Electrode Co., Ltd.