

TWE-711M

ASME / AWS E71T-1M
EN 758 T 42 2 P M 1 H10

Characteristics and Applications:

TWE-711M is a rutile type flux cored wire for mild steel and 490Mpa high tensile strength steel. It can be used with 75%Ar/25%CO₂, 80%Ar/20%CO₂ and 85%Ar/15%CO₂ shielding gas, offering a spray type transfer of weld metal. TWE-711M is suitable for butt and fillet welding in all positions. It has excellent usability with stable arc, less fume and spatter; good weld bead appearance and smooth slag removal ability.

Notes on Usage:

1. Excellent straight up weld ability.
2. Can be welded on zinc primer steel plate
3. Stable arc

Shielding Gas :

Ar-CO₂ mixture. 75%Ar to 85%Ar.

Polarity :

DCEP

Chemical Composition of All-Weld Metal (%) as per AWS : (80%Ar/20%CO₂)

	C	Mn	Si	P	S
Typical	0.04	1.22	0.39	0.016	0.006
Guaranty	<0.12	<1.75	<0.9	<0.03	<0.03

Mechanical Properties of All-Weld Metal as per AWS : (80%Ar/20%CO₂)

	0.2% OS (MPa)	TS (MPa)	EL. (%)	IV. (J)
Typical	500	557	30	-20°C : 90J
Guaranty	>400	>490	>22	-20°C >27J

Approvals :

ABS	LR	DNV	BV	GL	CWB
3SAHH, 3YSA	3S, 3YSH10	III YMS(H10)	S3YMH10	3YH10S	E491T-1M

Welding position



Welding Data (80%Ar/20%CO₂) :

Diameter (mm)	Weld Position	Amps	Volts	Wire-Feed Speed (in/min)	Deposition Rate (kg/hr)	Stick Out (mm)
1.2	Horizontal & Flat	200	24	300	3	20
		220	26	360	3.6	20
		250	26	450	4.5	20
		280	28	550	5.5	20
	Vertical up, Overhead	180	22	280	2.8	20
		220	24	380	3.8	20

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