

TWE-704-O

JIS Z3313 YFW-S50GB
AWS A5.20 E70T-4
DIN EN758 T 42 Z W N 4

Characteristics and Applications:

TWE-704-O is a self-shielded flux cored wire designed for welding low and medium carbon steels. It is suitable for flat, horizontal and downhill positions by DCEP polarity. The typical applications of TWE-704-O flux cored wire are structural steels and fabrication of machinery. It also can be applied to build up the worn parts.

Notes on Usage:

- 1.DC(+) polarity is recommended.
- 2.When impact toughness of weld metal is required, TWE-701 or TWE-711 would be recommended.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Al
0.25	0.34	0.30	0.015	0.006	1.50

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %
445	570	26

Sizes and recommended current range (DC <+>)

Diameter (mm)	φ 2.0mm	φ 2.4mm	φ 2.8mm
Parameters			
Voltage(Volt)	24-34	23-37	24-38
Current(Amp)	200-350	200-400	260-530
Stick out(mm)	40-60	40-60	40-60



No.6 Kai Fa 4TH Rd, Pao An Vill .,
Jen The Hsiang, Tainan Hsien, Taiwan
TEL:886-6-2663721
FAX:886-6-2664301
E-mail:ttec@ms6.hinet.net,
Http://www.tientai.com.tw