

TWE-721

AWS A5.26 EG72T-1

Characteristics and Applications:

TWE-721 is a self-shield flux cored wire used for one pass, vertical up welding of shipbuilding, heavy shop fabrication and structural welding.

It is suitable for 19-100 mm thick plate of mild steel and high tensile steel with high deposition rate of consumable guide self-shield electrogas welding process.

Notes on Usage:

1. Use DC(+) polarity.
2. The chemical composition of consumable guide tube is as close as possible to parent steel.
3. Mechanical properties are dependent on plate chemistry and joint geometry.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Mo
0.07	1.40	0.27	0.010	0.010	0.15

Typical mechanical properties of weld metal on A36 base metal

YP N/mm ²	TS N/mm ²	EL %	IV -29°C J
480	560	27	40

Sizes and recommended current range (DC <+>)

Parameters	Diameter (mm)			
	φ 3.0mm			
Thickness	19	25	38	50
Wire Feed Speed (cm/min)	510	580	750	890
Voltage(Volt)	35-38	38-40	42-44	42-44



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