

TWE-707-O

JIS Z3313 YFW-S50GB
AWS A5.20 E70T-7
DIN EN758 T 42 Z W N 4

Characteristics and Applications:

TWE-707-O is a self-shielded flux cored wire designed for high deposition welding. It is suitable for flat, horizontal and downhill positions on DCEN polarity. The typical applications of TWE-707-O are general fabrication and structural weldment where high deposition with good penetration and / or fast travel speed are needed.

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
0.34	0.43	0.15	0.030	0.020	1.30

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %
470	637	28

Sizes and recommended current range (DC <->)

Diameter (mm)	φ 1.6mm	φ 2.0mm	φ 2.4mm	φ 2.8mm
Voltage(Volt)	20-32	22-33	22-35	24-36
Current(Amp)	200-360	220-400	250-450	250-550
Stick out(mm)	35-45	35-45	40-55	40-55