

TWE-911Ni2

AWS A5.29 E91T1-Ni2C

Characteristics and Applications:

TWE-911Ni2 is a titania type flux-cored wire for all-position welding. It provides good weldability with smooth bead appearance, less spatter and stable arc as well as good impact properties down to -40°C.

It is suitable for welding of 2-3%Ni steel and 620 N/mm² HT steel on storage tanks, structures, bridges, construction machinery, shipbuilding and piping.

Notes on usage:

1. Use DC(+) polarity and 100% CO₂ shielding gas.
2. Excessive heat input should reduce impact value. Therefore, perform welding with selecting proper heat input based on the required impact value.
3. Keep the product dry, while it is stored or delivered.

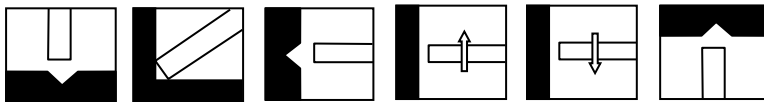
Typical chemical composition of weld metal (wt%) :

	C	Mn	Si	P	S	Ni
AWS	≤ 0.12	≤ 1.50	≤ 0.80	≤ 0.030	≤ 0.030	1.75-2.75
Typical value	0.06	1.25	0.45	0.012	0.007	2.40

Typical mechanical properties of weld metal:

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-lbf) -40°C (-40°F)
AWS	≥ 540(78)	620-760(90-110)	≥ 17	≥ 27(20)
Typical value	650(94)	710(103)	24	75(55)

Welding position:



Sizes and recommended parameter range (DC <+>):

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

Position	Diameter(mm)	1.2	1.6
	F · HF		180-300A / 26V-36V
VU · OH		150-220A / 24V-28V	160-220A / 24V-28V

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