Select 700GS

Description:

SELECT 700GS is a carbon steel, flux cored electrode for use without an external shielding gas. This electrode is intended for welding thin-gauge carbon steel, ranging from 3/16 " to 22 gauge. Applications are limited to single-pass weldments; this product is designed to weld quite effectively over galvanized material and can be used on certain aluminized surfaces as well. **SELECT 700GS** requires no external gas- shielding and should be welded with DCEN (straight polarity).

Classification:

- E71T-GS, E71T-14 per AWS A5.20, SFA 5.20.

Characteristics:

SELECT 700GS is a self- shielded, flux cored electrode which combines superb welder appeal with exceptional quality and consistency. The arc transfer is smooth and stable, with virtually no spatter emission. This "soft" arc transfer minimizes burn-through on thin gauge material, making the welder's job much easier. This slag system enables the electrode to weld in all positions and also to make welds at high speed. Availability of diameters down to .030" makes this product a fine choice for use on the popular 110 volt power sources. Advanced manufacturing techniques ensure the highest levels of quality, consistency, and performance.

Applications:

The many positive characteristics of **SELECT 700GS** make it the natural choice for applications such as lap and butt welds on galvanized sheet metal, repair of automobile sheet metal, welding ductwork, and joining of galvanized roofing sheet metal. This electrode is a natural choice for high speed welds on sheet metal up to 3/16" thick, especially galvanized, aluminized, or other coated steels. The small diameters of this product are ideal for the "hobbyist" welder, as they work very well on the small 110 volt power source/feeders, which have become so popular. The ability to weld without a shielding gas enhances the versatility and portability of this electrode.

Typical Mechanical Properties:

Transverse Tensile Strength (psi):	86,400 (Base metal fracture)
Guided Bend Test:	Meets AWS requirements

Recommended Welding Parameters:

Diam (in)	Amps	Volts	WFS	Deposition Rate Lb/Hr	Deposition Eff.%
.030"	50	15	80	1.2	85
	100	16	225	1.8	
	150	17	375	2.7	
	175	17	445	3.3	
.035"	75	15	70	1.2	90
	100	16	110	1.9	
	150	17	180	3	
	200	18	305	4.5	
.045"	100	15	70	1.5	90
	150	16	120	2.2	
	200	17	195	4.5	
	225	18	245	5.1	
1/16"	150	17	60	3.3	93
	200	18	85	3.8	
	250	18	135	5	
	300	19	180	7.8	
5/64"	200	19	60	3.6	87.5
	250	20	80	4.4	
	300	21	115	5.7	
	325	120	6.6		

700GS Data using DCEN

Recommended Stick out Diameter	**(mm)**	**E.S.O.**
.030”	0.8	3/8”-1/2”
.035”	0.9	3/8”-1/2”
.045”	1.2	3/8”-1/2”
1/16”	1.6	½”-3/4”
5/64”	2.0	¾”-1”

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Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.