



Select 707

Description:

- A carbon steel, all position, flux cored electrode for all position welding with gas shielding
- Can be used with both 100% CO₂ and 75-80% Ar/balance CO₂ shielding gases
- Good welding performance across a range of welding parameters
- Maintains superior arc stability at lower than normal current settings

Classifications & Approvals:

- E71T-1M-H8, E71T-1C-H8, E71T-9M-H8 and E71T-9C-H8 per AWS A5.20, ASME SFA5.20
- E71T1-M21A2-CS2-H8 and E71T1-C1A2-CS2-H8 per AWS A5.36, ASME SFA5.36
- Certified by CWB to CSA W48-06 classification E491T-9M-H8 and E491T-9C-H8

Typical Mechanical Properties:

	75-80% Ar/balanceCO ₂	100% CO ₂
Ultimate Tensile Strength (psi)	91,000	89,000
Yield Strength (psi)	78,300	79,000
Percentage Elongation	29	27
CVN (ft • lbf) @ -20° F	65	53

Typical Weld Deposit Composition (wt%):

Shielding Gas	C	Mn	P	S	Si
75-80% Ar/balanceCO ₂	.05	1.40	.012	.009	.78
100% CO ₂	.05	1.19	.012	.010	.63

Recommended Welding Parameters (100% CO₂*):

Diameter	Position	Optimum			Range		CTWD
		Amperage	WFS (iom)	Voltage	Amperage	Voltage	
1/16"	Flat	320	325	29	150-360	23-31	1"-1 1/4"
	Overhead	180	225	26	150-260	23-28	
	Vertical up	180	225	25	150-250	23-27	
.052"	Flat	360	270	28	120-340	20-31	3/4"-1"
	Overhead	240	210	26	120-260	21-28	
	Vertical up	240	210	25	120-250	21-27	
.045"	Flat	440	250	28	100-290	23-30	3/4"-1"
	Overhead	310	195	26	100-250	22-29	
	Vertical up	310	195	25	100-240	22-28	

* For 75-80%Ar/balance CO₂ shielding gas, lower the voltage by 1 to 1.5 volts. A contact tip to work distance of 3/4 to 1" is recommended.

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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.