



Select 70C-10

Description:

- A carbon steel, composite metal cored electrode for gas shielded arc welding
- Designed for high speed welding of thin gauge carbon steels
- Travel speeds of 85-100 ipm are readily achievable
- Performance of this product is not dependent on high technology power sources; a standard CV machine produces excellent results
- Intended to use with shielding gas blends of 75-95% Ar/balance CO₂
- This electrode is designed for single pass welding

Classification:

- E70C-GSM per AWS A5.18, ASME SFA5.18
- E70TGS-M21Z-G, E70TGS-M24Z-G per AWS A5.36, ASME SFA5.36

Recommended Welding Parameters* & Deposition Rates:

<u>Diameter</u>	<u>ESO</u>	<u>Amps</u>	<u>Volts</u>	<u>WFS</u>	<u>Deposition Rate lb/hr</u>
.052	"½"-1"	N/A	29	240	7.2
			30	360	11.0
			33	495	15.0
			35	640	19.5
			33	695	22.2
1/16"	½"-1"	N/A	26	200	8.0
			28	300	13.8
			31	415	17.7
			33	500	23.1
			35	615	29.3
5/64"	¾"-1"	N/A	29	230	11.5
			30	260	13.0
			31	290	14.5
			33	350	17.5
			34	400	20.0
			35	500	25.0

* Welding parameters are for 75-80% Ar/balance CO₂. At higher levels of argon the voltage should be gradually decreased; ½-1 volt for 85% Ar/15% CO₂, 1-1½ volts for 90% Ar/10% CO₂ and 1-2 volts for 95% Ar/5% CO₂.

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 for any particular purpose with respect to its products.

Rev 1 (02/13/2019)