



Select 70C-10

Classification:

E70C-GSM per AWS A5.18, SFA 5.18

Description:

Select 70C-10 is a carbon steel, metal cored, composite electrode for use with external shielding gas. It is intended for single pass welding of carbon and certain low alloy steels. Recommended shielding gases are mixtures of argon/carbon dioxide, with a minimum of 75% argon. Flow rates of 40-55 cfh should be utilized, and dew points must be at least -40°F.

Characteristics:

Select 70C-10 is a metal cored electrode designed specifically for high speed welding of thin gauge carbon steel. Travel speeds of 85-100 ipm are readily achievable, with excellent bead profile and appearance. These speeds do not require the use of special power sources; a conventional CV power source is acceptable. There is minimal slag residue, and penetration is adequate for most applications. As with all metal cored wires, there is improved sidewall fusion, better performance on poor fit up, and superior ability to bridge gaps, when compared to solid wires. Select 70C-10 is manufactured with state-of-the-art equipment, ensuring the highest level of quality, consistency, and performance in the industry.

Applications:

Select 70C-10 is well suited to single pass weldments requiring extra high travel speeds, such as in automobile components, truck parts, suspension and undercarriage assemblies, and truck frames.

Recommended Welding Parameters* & Deposition Rates

Diameter	ESO	Amps	Volts	WFS	Deposition Rate lb/hr
.052	"½"-1"	200	29	240	7.2
				250	
			30	360	11.0
				300	
			33	495	15.0
				350	
1/16"	½"-1"	250	35	640	19.5
				375	
			33	695	22.2
			1/16"	200	8.0
				300	
5/64"	¾"-1"	300	28	300	13.8
				350	
			31	415	17.7
				400	
			33	500	23.1
				450	
			35	615	29.3
			5/64"	230	11.5
				350	
			30	260	13.0
				400	
31	290	14.5			
	450				
33	350	17.5			
	500				
34	400	20.0			
	550				
35	500	25.0			

* Welding parameters are for 75% Ar/25% 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.

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