

Select 70C-6 ZN

Description:

Select 70C-6 ZN is a premier carbon steel, composite metal cored electrode designed to produce a highly stable arc through CV and Pulse parameters. Through unique alloying techniques the Select 70C-6 ZN not only exhibits superior arc performance with no spatter, but also produces defect free welds on galvanized carbon steels. High travel speeds of 80 inches per minute are realized over coated and bare carbon steels as a result of the fine spray transfer. It is ideal for thin galvanized materials and bare carbon steel components which require spatter free surfaces.

Classification:

- E70C-6M-H4 per AWS A5.18, ASME SFA 5.18

Advantages:

- Stable arc with fine spray transfer producing spatter free welds at high travel speeds (80i.p.m.)
- Welds through galvanized coated carbon steel without defects
- Metal cored formula promotes increased travel speed with better sidewall fusion
- True spray transfer with virtually no spatter capable of bare and coated materials
- Very low diffusible hydrogen levels, less than 4.0mL/100g

Typical Mechanical Properties:

	<u>75% Ar/25%CO₂</u> <u>As-Welded</u>
Ultimate Tensile Strength (ksi)	78.1
Yield Strength (ksi)	65.7
Elongation (%)	34
CVN (ft-lbs) @ -20°F	82

Typical Deposit Composition:

	Wt. %	<u>C</u>	<u>Mn</u>	<u>P</u>	<u>S</u>	<u>Si</u>	<u>Ni</u>	<u>Cr</u>	<u>Mo</u>	<u>V</u>	<u>Cu</u>
75% Argon / 25% CO ₂		0.03	1.53	0.008	0.01	0.67	0.01	0.02	0.003	0.00	0.04

Typical Welding Parameters*:

<u>Diameter (in.)</u>	<u>Optimum</u>			<u>Range</u>			<u>ESO</u>
	<u>Amperage</u>	<u>WFS</u>	<u>Voltage</u>	<u>Amperage</u>	<u>WFS</u>	<u>Voltage</u>	
.035	220	550	29.5	140-280	250-780	21-34	½"-3/4"
.045	260	375	29	160-365	170-650	19-33	½"-3/4"
.052	300	325	30	195-400	170-550	21-33	½"-3/4"

* 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, 1-1 1/2 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.