

## Select 70TR

### Description:

- A carbon steel, flux cored, gas shielded electrode for single and multiple pass welding
- Welding positions are flat and horizontal fillets and flat grooves
- This product is designed to produce perfectly flat horizontal, equal legged fillets, with no double bead effect
- Can be used with either 100% CO<sub>2</sub> or 75-80% Ar/balance CO<sub>2</sub> shielding gas
- Beads can be "stacked" in a horizontal fillet with no drooping or roll on the bead surface
- Ideal for those structural welds or general fabrications where bead geometry and cosmetics are of primary importance

### Classifications:

- E70T-1C-H8, E70T-1M-H8, E70T-9C-H8, E70T-9M-H8 per AWS A5.20, ASME SFA 5.20
- E70T1-C1A2-CS1-H8, E70T1-M21A2-CS1-H8 per AWS A5.36, ASME SFA5.36
- ABS E70T-1C, per AWS A5.20, SFA 5.20.
- CWB E492T-9-H8
- AWS D1.8 (Seismic) approval CO<sub>2</sub> and 75-80% Ar/balance CO<sub>2</sub> for 3/32"

### Typical Mechanical Properties:

	<u>CO<sub>2</sub></u>	<u>75-80% Ar/balance CO<sub>2</sub></u>
Ultimate Tensile Strength (psi)	88,700	94,100
Yield Strength (psi)	74,400	81,100
Percent Elongation	24	24
CVN (ft-lbf) @ 0°F		
CVN (ft-lbf) @ -20°F	31	30

### Typical Deposit Composition (wt%):

<u>Shielding Gas</u>	<u>C</u>	<u>Mn</u>	<u>Si</u>	<u>P</u>	<u>S</u>
100 CO <sub>2</sub>	.06	1.56	.58	.006	.010
75% Ar/balance CO <sub>2</sub>	.06	1.68	.70	.007	.009

### Recommended Welding Parameters:

<u>Diam.</u>	<u>Optimum</u>			<u>Range</u>			<u>ESO</u>
	<u>Amps</u>	<u>Volts</u>	<u>WFS</u>	<u>Amps(DCEP)</u>	<u>Volts</u>	<u>WFS(in/min)</u>	
3/32"	425	29	180	300-500	26/34	110-240	1-1¼"
5/64"	350	29	250	280-430	26-33	140-300	1-1¼"
1/16"	300	27	320	150-350	24/34	130-385	1-1¼"
.045	250	28	450	130-300	21/32	175-570	½"-1"

Gas Flow Rate: 40-55 cfh

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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.