

Select 71

Description:

- A carbon steel, flux cored, gas shielded electrode for single and multiple pass welding of horizontal and flat fillets and flat groove welds
- A general purpose electrode with high levels of deoxidation for welding over mill scale and other oxide contaminants
- Designed to operate with 100% CO₂ shielding gas
- Well suited for welding carbon steels such as ASTM A36, A285, A515, and A516
- Ideal for general fabrication and structural welding
- Typical applications are railcar fabrication, structural steel, and construction equipment

Classifications & Approvals:

- E70T-1C, E70T-9C per AWS A5.20, ASME SFA 5.20
- E70T1-C1A2-CS1 per AWS A5.36, ASME SFA5.36
- ABS E70T-1C per AWS A5.20, SFA 5.20
- CWB E492T-9-H8 (CO₂)

Typical Mechanical Properties:

	<u>100% CO₂</u>
Ultimate Tensile Strength (psi)	88,600
Yield Strength (psi)	73,000
Percent Elongation	24
CVN (ft-lbf) @ 0°F	34
@-20° F	29

Typical Deposit Composition (100% CO₂):

<u>Wt%</u>	<u>C</u>	<u>Mn</u>	<u>Si</u>	<u>P</u>	<u>S</u>
	.06	1.56	.58	.006	.010

Recommended Welding Parameter:

<u>Diam.</u>	<u>Optimum</u>			<u>Range</u>			
	<u>Amps</u>	<u>Volts</u>	<u>WFS</u>	<u>Amps</u>	<u>Volts</u>	<u>WFS(in/min)</u>	<u>ESO</u>
1/8"	500	29	110	375-725	28/37	65-175	1-1¼"
7/64"	475	29	140	350-700	27/36	80-250	1-1¼"
3/32"	425	29	180	300-550	26/34	110-270	1-1¼"
5/64"	350	29	250	280-430	26/33	140-300	1-1¼"
1/16"	300	29	300	150-350	25/34	130-375	¾ -1"
.052"	275	28	400	150-375	24/32	140-580	¾ -1"
.045"	250	28	450	130-300	24/32	175-570	½"-1"

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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.