Select 71

Description:

Select 71 is a carbon steel electrode for flux cored arc welding with external gas shielding. It is intended for single and multiple pass welding of carbon, and certain low alloy, steels in the flat and horizontal fillet positions. This electrode is designed for use with carbon dioxide shielding gas. Gas flow rates should be maintained at 35-50 cfh. Dew point of the gas must be at least -40°F.

Classifications & Approvals:

- E70T-1C, E70T-9C per AWS A5.20, SFA 5.20.
- ABS E70T-1C, CWB E492T-9-H8 (CO2)

Characteristics:

Select 71 is a general purpose E70T-1C electrode with good welder appeal. This electrode has a smooth arc transfer, low spatter and produces a uniform, well washed bead. The high level of deoxidation facilitates welding over mill scale, rust, and other mild contaminants on the plate. New manufacturing technology ensures the finest in quality, consistency, and welding performance in the entire flux cored industry.

Applications:

Select 71 is ideal for those applications involving the welding of structural carbon steels, where high deposition rates and superior penetration characteristics are preferred. **Select 71** is an ideal choice for welding steels such as A36, A285, A515, and A516.

Typical Mechanical Properties – CO2 Shielding Gas:

Ultimate Tensile Strength (psi)	88,600
Yield Strength (psi)	73,000
Percent Elongation	24
CVN (ft•lb *ƒ*) @ 0°F	34
@-20° F	29

Typical Deposit Composition:

Wt%	C	Mn	Si	P	S
	.06	1.56	.58	.006	.010

Recommended Welding Parameter:

	Optimum			Range			
Diam.	Amps	Volts	WFS	Amps	Volts	WFS(in/min)	ESO
1/8"	500	29	110	375-725	28/37	65-175	¾"-1¼"
7/64"	475	29	140	350-700	27/36	80-250	¾"-1¼"
3/32"	425	29	180	300-550	26/34	110-270	¾"-1¼"
5/64"	390	29	250	280-430	26/33	140-300	¾"-1¼"
1/16"	330	29	330	150-400	22/34	130-500	½"-1"
.052"	275	28	400	150-375	20/32	140-580	½"-1"
.045"	250	28	450	130-300	21/32	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.