



Select 710

Description :

- A carbon steel, gas shielded, flux cored electrode for single and multiple pass welding
- Intended for all position welding of carbon steels, such as ASTM A36, A285, and A515-Gr 70
- Can be used with both 100% CO₂ and 75-80% Ar/balance CO₂ shielding gases
- Arc transfer is small to medium droplet spray mode, with 75-80% Ar/balance CO₂ providing the smaller droplet mode
- An excellent electrode for general purpose welding of structural steel and various fabrications
- Typical applications include structural welding, farm machinery, and water towers

Classifications:

- E71T-1C and E71T-1M per AWS A5.20, ASME SFA 5.20
- E71T1-M21A0-CS1 and E71T1-C1A0-CS1 per AWS A5.36, ASME SFA 5.36

Typical Mechanical Properties:

	<u>100% CO₂</u>	<u>75-80% Ar/balance CO₂</u>
Ultimate Tensile Strength (psi)	86,700	88,000
Yield Strength (psi)	70,500	71,000
Percentage Elongation	26	26
CVN (ft•lbf) @ 0° F	58	65

Typical Weld Deposit Composition (wt%):

<u>Shielding Gas</u>	<u>C</u>	<u>Mn</u>	<u>P</u>	<u>S</u>	<u>Si</u>
100% CO ₂	.05	1.00	.008	.010	.74
75-80% Ar/balance CO ₂	.05	1.10	.010	.010	.85

Recommended Welding Parameters (100CO₂*):**

<u>Diameter</u>	<u>Position</u>	<u>Optimum</u>			<u>Range</u>	
		<u>Amperage</u>	<u>WFS</u>	<u>Voltage</u>	<u>Amperage</u>	<u>Voltage</u>
1/16"	Flat	350	350	29	150-400	22-34
	Overhead	225	180	26	150-310	22-28
	Vertical up	225	180	25	150-280	22-27
.052"	Flat	300	440	28	100-330	19-32
	Overhead	200	245	26	150-310	21-28
	Vertical up	200	245	25	150-280	21-27
.045"	Flat	250	450	28	100-300	21-32
	Overhead	190	305	26	150-280	21-29
	Vertical up	190	305	25	100-230	21-28

* For 75Ar-25CO₂ shielding gas, lower the voltage by 1 to 1.5 volts

** Other diameters available upon request

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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. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.