



Select 710

Description:

Select 710 is an all-position flux cored, gas shielded electrode designed for single and multi-pass welding applications. This electrode is developed to operate with a smooth and stable arc on 100%CO₂ or Argon/ 20-25% CO₂ shielding gas. It is ideal for use on general fabrication, structural steel, construction equipment and farm machinery.

Classifications:

- E71T-1C and E71T-1M per AWS A5.20
- E71T1-M21A0-CS2 and E71T1-C1A0-CS2 per AWS A5.36

Advantages:

- Produces excellent bead geometry using 100%CO₂ or Argon/ 20-25% CO₂
- A deep penetrating arc reduces potential for lack of fusion
- A good general purpose electrode

Typical Mechanical Properties:

	<u>100CO₂</u>	<u>75Ar/25CO₂</u>
Ultimate Tensile Strength (psi)	86,700	88,000
Yield Strength (psi)	70,500	71,000
Percentage Elongation	26	26
CVN (ft • lb) @ 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>
<u>100CO₂</u>	.05	1.00	.008	.010	.74
<u>75Ar/25CO₂</u>	.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
.035"	Flat	200	600	26	100-250	21-30
	Overhead	160	410	24	100-175	21-26
	Vertical up	160	410	24	100-175	21-26

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

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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.