

Select 71A

Description:

- A carbon steel, flux cored, gas shielded electrode for single and multiple pass welding
- Intended for welding horizontal and flat fillets, and flat groove welds
- Designed for use with 100% CO₂ shielding gas
- Arc transfers in a small droplet spray, with improved stability at lower currents
- The slag is typically self peeling, and removes very cleanly
- Usually used to weld steels such as ASTM A36, A285, A515-Grade 70, and A516-Grade 70
- Well suited for structural welding, general fabrication, welding rail cars and construction machinery, and welding earthmoving machinery

Classifications & Approvals:

- E70T-1C, E70T-9C per AWS A5.20, ASME SFA 5.20
- E70T1-C1A2-CS1 per AWS A5.36, ASME SFA5.36

Typical Mechanical Properties (100% CO₂):

Ultimate Tensile Strength (psi)	88,000
Yield Strength (psi)	74,000
Percent Elongation	23
CVN (ft-lbf) @ 0°F	32
@-20° F	21

Typical Deposit Composition (100% CO₂):

Wt%	C	Mn	Si	P	S
	.06	1.28	.54	.008	.011

Recommended Welding Parameters:

Diam.	Optimum			Optimum			ESO
	Amps	Volts	WFS	Amps	Volts	WFS	
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	330	150-400	24/34	130-500	1-1¼"

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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.