

## Select 720A

### Description :

- A carbon steel, gas shielded, flux cored electrode for all position welding
- Designed for single and multiple pass welding of carbon steels, such as ASTM A36, A285, and A515-Gr 70
- Can be used with either 100% CO<sub>2</sub> or 75-80% Ar/balance CO<sub>2</sub>
- Improved arc stability at lower amperage/voltage settings allows for welding on thinner sections
- Intended for welding structural steel and general fabrication, especially on thinner gauges, down to 3/16 in
- Typical applications are railcar construction, pipe welding, and offshore platform construction

### Classifications & Approvals:

- E71T-1C, E71T-1M, E71T-9C and E71T-9M per AWS A5.20, ASME SFA 5.20
- E71T1-M21A2-CS1 and E71T1-C1A2-CS1 per AWS A5.36, ASME SFA 5.36

### Typical Mechanical Properties:

	<u>100% CO<sub>2</sub></u>	<u>75-80% Ar/balance CO<sub>2</sub></u>
Ultimate Tensile Strength (psi)	83,000	86,500
Yield Strength (psi)	75,300	78,400
Percentage Elongation	28	27
CVN (ft•lbf) @ -20° F	58	59

### 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 <sub>2</sub>	.05	1.21	.008	.010	.38
75-80% Ar/balance CO <sub>2</sub>	.05	1.37	.008	.009	.42

### Recommended Welding Parameters (100CO<sub>2</sub>\*):

<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	300	29	150-400	22-34
	Overhead	225	160	26	150-310	22-28
	Vertical up	225	160	25	150-280	22-27
.052"	Flat	300	360	28	100-330	19-32
	Overhead	225	245	26	150-310	21-28
	Vertical up	225	245	25	150-280	21-27
.045"	Flat	250	410	28	100-300	21-32
	Overhead	200	265	26	150-280	21-29
	Vertical up	200	265	25	100-230	21-28

\*For 75-80% Ar/balance CO<sub>2</sub> 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.