



Select 730C

Description:

Select 730C is an all position, flux cored, gas shielded electrode designed for single or multiple pass welding of carbon and certain low alloy steels. This electrode is intended for use with 100% CO₂ shielding gas. Mechanical properties are excellent, and CVN impact values are particularly good, at temperatures as low as -20°F. This product is optimized for superb arc transfer characteristics with 100% CO₂ shielding gas, with the transfer mode being small droplets and resembling the molten metal spraying onto the welding puddle. The **Select 730C** is well suited for structural steel welding, shipbuilding, barge construction, and general plate fabrication.

Classifications & Approvals:

- E71T-1C-DH8, E71T-9C-DH8 per AWS A5.20
- E71T1-C1A2-CS1-DH8 per AWS A5.36
- ABS 3SA-3YSA, DNV III YMS (100% CO₂)
- AWS D1.8:2016 .052" and 1/16" (100% CO₂)

Advantages:

- Excellent notch toughness using 100%CO₂
- Low fume generation rates and minimal spatter emission
- Excellent bead geometry and all-position weldability
- Smooth spray transfer mode

Typical Mechanical Properties:

	100% CO ₂
Ultimate Tensile Strength (psi)	83,500
Yield Strength (psi)	75,000
Percentage Elongation	30
CVN (ft-lbf) @ 0° F	77
@ -20° F	61

Typical Weld Deposit Composition (wt%):

Shielding Gas	C	Mn	P	S	Si
100%CO ₂	.04	1.20	.008	.010	.63

Recommended Welding Parameters (CO₂)*:

Diameter	Position	WFS	Optimum		Range		CTWD
			Amperage	Voltage	Amperage	Voltage	
1/16"	Flat	350	350	28	150-400	22-33	¾"-1"
	V-Up/OH	225	180	25	150-310	22-28	
.052"	Flat	440	300	27	100-330	19-31	¾"-1"
	V-Up/OH	245	200	25	150-310	21-28	
.045"	Flat	450	250	27	100-300	21-31	¾"-1"
	V-Up/OH	305	190	25	150-280	21-29	

Rev 5 (1/2019)

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.