

Select 74

Description:

Select 74 is a carbon steel, flux cored electrode for use without external gas-shielding in multiple pass welding of carbon steels. This electrode is intended for flat position welding of grooves and fillets and horizontal fillet welding with extremely high deposition rates.

Classification:

- E70T-4 per AWS A5.20, SFA 5.20.

Characteristics:

Select 74 is a self-shielded, flux cored electrode intended to weld with a globular transfer, moderate spatter, and high deposition rates. The highly basic slag minimizes hot cracking on steels high in sulfur. Joint penetration is not as great as with E70T-1 electrodes, which facilitates welding fillets with gaps or poor fit up. Slag detachment is quite good, and the bead profile is slightly convex.

Applications:

Select 74 is ideal for those welding applications where gas- shielded electrodes may have problems, such as outdoors or in windy conditions. These would typically be light gauge steel plate fabrication or general purpose fabrication of carbon steels. **Select 74** is also a good choice in poor fit up situations or when extended stickouts must be used in hard-to-reach areas.

Typical Mechanical Properties:

Ultimate Tensile Strength (psi):	87,800
Yield Strength (psi):	65,000
Percent Elongation:	26.5

Typical Deposit Composition:

<u>Wt%</u>	<u>C</u>	<u>Mn</u>	<u>Si</u>	<u>P</u>	<u>S</u>	<u>Al</u>
	.20	.50	.17	.008	.003	1.59

Recommended Welding Parameters (DCEP):

Optimum				
<u>Diam.</u>	<u>Amps</u>	<u>Volts</u>	<u>WFS(ipm)</u>	<u>CTWD</u>
1/16"	200	30	205	1¾"
5/64"	250	30	185	2¾"
3/32"	350	30	190	2¾"
.120"	450	31	135	2¾"

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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. Select-Arc disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.