

## Select 75

### Description:

- A carbon steel, flux cored, gas shielded electrode for welding flat and horizontal fillet and flat groove welds
- Can be used with both 100% CO<sub>2</sub> and 75-80% Ar/balance CO<sub>2</sub> shielding gases
- This product utilizes a lime-fluoride, or (chemically) basic slag, as opposed to the acid, or rutile, slag systems of the E7XT-1 electrodes
- Basic slags produce weld deposits which are low in oxygen, have low diffusible hydrogen levels, and exhibit outstanding mechanical properties
- Arc transfer is a large droplet, globular mode
- Intended for structural welding and plate fabrications of carbon steels, such as ASTM A36, A285, A515-Gr 70, and A516-Gr 70
- Typical applications include earthmoving equipment, mining machinery, cranes, and boom sections

### Classifications & Approvals:

- E70T-5C-H4, E70T-5M-H4 per ANSI/AWS A5.20, ASME SFA 5.20
- E70T5-C1A2-CS1-H4, E70T5-M21A2-CS1-H4 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)	81,400	87,000
Yield Strength (psi)	68,200	71,800
Percent Elongation	30	28
CVN (ft·lbf) @ -20° F.	77	79

### Typical Deposit Chemistry:

<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	1.29	.009	.010	.44
75-80% Ar/balance CO <sub>2</sub>	.04	1.46	.008	.010	.57

### Suggested Welding Parameters:

<u>Diameter</u>	<u>Optimum</u>			<u>Range</u>	
	<u>Amperage</u>	<u>Voltage</u>	<u>WFS</u>	<u>Amperage</u>	<u>Voltage</u>
1/8"	475	28	115	375-650	26-36
3/32"	400	28	185	350-550	26-34
5/64"	370	28	250	280-500	26-33
1/16"	300	29	320	250-450	26-34
.045"	250	28	380	120-320	22-31

Rev 1 (02/20/2019)

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.