



## SELECT 95-K2

**Description:**

The outstanding mechanical properties of **Select 95-K2**, particularly the low temperature CVN values, make this an excellent choice for welding steels requiring a minimum of 90,000 psi tensile strength and good subzero CVN toughness. This basic electrode is designed for single and multiple pass welding of horizontal fillets and flat position weldments for specific low alloy steels.

**Classification:**

- E90T5-K2C per AWS A5.29, ASME SFA 5.29

**Characteristics:**

- 1 3/4% nickel and 1/4% molybdenum weld deposit.
- Excellent low temperature CVN toughness.
- Extremely low diffusible hydrogen levels.
- High basicity, lime-flouride slag

**Applications:**

**Select 95-K2** is well suited for steels such as HY-80, HY-100, ASTM A710 and A514. Typical applications would be the welding of aircraft carriers, submarines, oil exploration equipment, mobile cranes and earthmoving machinery.

**TYPICAL MECHANICAL PROPERTIES**

Ultimate Tensile Strength (psi)	95,800
Yield Strength (psi)	86,100
Percent Elongation	23
CVN (ft • lb f) @ -60° F	44

**TYPICAL DEPOSIT COMPOSITION**

Wt %	C	Mn	Si	P	Ni	Mo	S
	.04	1.30	.50	.009	1.75	.20	.010

**Suggested Welding Parameters:**

Diameter	Amperage	Optimum	WFS	Range	
		Voltage		Amperage	Voltage
3/32"	400	28	185	350-550	26-34
5/64"					
1/16"	300	29	320	250-450	26-34
.045"	250	28	380	120-320	22-31

Rev 0 (03/18/2014)

**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.