

Select 97

Description:

- A carbon steel, flux cored, gas shielded electrode for welding in the flat and horizontal positions
- Can be used with 100% CO₂ or with 75-80% Ar/balance CO₂ shielding gas
- Lower fume generation rates than conventional E70T-1 electrodes
- Stable arc transfer over a wide range of welding parameters
- With both shielding gases, arc transfer is a small droplet transfer with low spatter
- Ideal for structural welds and general steel fabrications
- Limited to horizontal and flat fillets, and flat groove welds

Classifications & Approvals:

- E70T-1C, E70T-1M, E70T-9C, E70T-9M per AWS A5.20, ASME SFA 5.20
- E70T1-C1A2-CS1, E70T1-M21A2-CS1 per AWS A5.36, ASME SFA5.36
- ABS E70T-1C
- CWB E492T-9-H8

Typical Mechanical Properties:

	<u>100% CO₂</u>	<u>75-80% Ar/balance CO₂</u>
Ultimate Tensile Strength (psi)	82,000	89,000
Yield Strength (psi)	77,800	75,300
Percent Elongation	25	24.6
CVN (ft•lbf) @ -20°F	27	38

Typical Deposit Composition:

<u>Shielding Gas</u>	<u>C</u>	<u>Mn</u>	<u>Si</u>	<u>P</u>	<u>S</u>
100% CO ₂	.03	1.55	.50	.010	.010
75-80% Ar/balance CO ₂	.04	1.70	.40	.007	.008

Recommended Welding Parameters*:

<u>Diam.</u>	<u>Optimum</u>			<u>Range</u>			
	<u>Amperage</u>	<u>Voltage</u>	<u>WFS</u>	<u>Amperage</u>	<u>Voltage</u>	<u>WFS</u>	<u>CTWD</u>
3/32"	450	31	210	275-550	26/34	120-270	1"
5/64"	390	29	250	280-430	26/33	140-300	1"
1/16"	350	29	360	250-400	26/32	220-410	1"
.052	275	28	400	150-375	20/32	140-580	¾ -1"
.045"	250	28	450	130-300	21/32	175-570	¾"

* With CO₂ shielding gas. Reduce voltage by 1 volt for 75-80% Ar/balance CO₂.

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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 of fitness for any particular purpose with respect to its products.