



## Select Super 72

### Description:

Select Super 72 is a carbon steel, flux cored electrode for use with external gas shielding. This electrode is intended for single pass welding of carbon steel in the flat and horizontal positions. The recommended shielding gas is 100% carbon dioxide. Gas flow rates should be at 35-50 cfh, and a minimum dew point of -40°F should be maintained.

### Classification:

- E70T-2C per AWS A5.20, SFA 5.20.

### Characteristics:

Select Super 72 is a gas-shielded, flux cored electrode with a rutile based slag system, which produces a smooth spray-like arc transfer with low spatter. The bead profile is somewhat convex; slag coverage is complete, and the slag volume is quite low. A high level of deoxidation allows Select Super 72 to weld successfully over mill scale, rust, and other contaminants. The thin, fluid slag facilitates fast travel speeds and good bead profiles in lap, seam and butt welding applications.

### Applications:

Select Super 72 is a superb selection for single pass welds on thin gauge applications, particularly lap and butt welds, on carbon steels. The high deoxidizer content provides for clean, porosity free welds on heavily oxidized steels and steels with certain glass coatings. Typical applications include wheel and hub assemblies and hot water heater assemblies, particularly the flue and bottom weldments.

### Typical Mechanical Properties:

Transverse Tensile Strength (psi) 85,700 (base metal fracture)  
Guided Bend Test Meets AWS requirements

### Recommended Welding Parameters:

Diam.	Optimum			Range			ESO
	Amperage	Voltage	WFS	Amperage	Voltage	WFS	
1/8"	500	29	110	375-725	28/37	65-175	3/4"-1 1/4"
7/64	475	29	140	350-700	27/36	80-250	3/4"-1 1/4"
3/32"	425	29	180	300-550	26/34	110-270	3/4"-1 1/4"
5/64"	390	29	250	280-430	26/33	140-300	3/4"-1 1/4"
1/16"	330	29	330	150-400	22/34	130-500	1/2"-1"
.052"	275	28	400	150-375	20/32	140-580	1/2"-1"
.045"	250	28	450	130-300	21/32	175-570	1/2"-1"

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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.