Select 105-D2

Low Alloy / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Low alloy steel electrode designed to weld certain manganese-molybdenum steels (such as ASTM A302) and castings (such as ASTM A49, A291, and A735)
- Basic slag system allows the product to exhibit excellent low temperature impact properties

CONFORMANCES

AWS A5.29 E100T5-D2C

DIAMETERS (in (mm))

3/32 (2.4)

POSITIONS

SHIELDING GAS

100% CO2
Flow Rate: 40 - 50 CFH

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Shielding Gas	C	Mn	Mo	P	S	Si
100%CO2	0.08	2.01	0.49	0.013	0.010	0.25

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp	CVN @ -40°F (-40°C) ft-lb (J)
100%CO2	110 (759)	96 (664)	24	PWHT	1150°F for 1 hr	41 (56)

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
3/32 (2.4 mm)	100% CO2	Flat & Horizontal	145 (3.7)	320	25	1 (25)
		Flat & Horizontal	160 (4.1)	345	27	1 1/4 - 1 1/2 (32 - 38)
		Flat & Horizontal	170 (4.3)	370	29	1 1/4 - 1 1/2 (32 - 38)

** WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance*
***The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with "all-position" capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn't limited to the listing.*

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PACKAGING [lbs [kgs]]

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

**Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.*

STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.

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