Select 130-C

Low Alloy / Gas Shielded / Metal Cored

PRODUCT DATA SHEET

FEATURES

- This electrode is intended for single and multiple pass welding of certain high strength, low alloy steels, in the flat and horizontal positions.
- Ideal choice for joining low alloy, high strength steels such as HY-100 and A514.
- This electrode is specifically formulated for superior arc stability, making it suitable for high strength steel robotic welding applications.

CONFORMANCES

AWS A5.28	E120C-G
ASME SFA 5.28	E120C-G

DIAMETERS (in (mm))

0.040 (1.0), 0.045 (1.2)

POSITIONS

SHIELDING GAS

90% Ar/ 10% CO2
Flow Rate: 40 - 50 CFM

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Shielding Gas	C	Cr	Mn	Mo	Ni	P	S	Si
90%Ar / 10%CO2	0.08	0.33	1.91	0.48	2.28	0.008	0.008	0.66

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp
90%Ar / 10%CO2	140 (966)	129 (890)	20	As-Welded	-

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RECOMMENDED WELDING PARAMETERS

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.040 (1.0 mm)	75% Ar/25% CO2	Flat & Horizontal	185 (4.7)	300	25	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	205 (5.2)	365	26	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	225 (5.7)	420	27.5	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	240 (6.1)	490	29	5/8 - 3/4 (16 - 19)
0.045 (1.2 mm)	75% Ar/25% CO2	Flat & Horizontal	200 (5.1)	260	25	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	220 (5.6)	305	26	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	240 (6.1)	360	27.5	5/8 -3/4 (16 - 19)
		Flat & Horizontal	255 (6.5)	405	29	5/8 -3/4 (16 - 19)

** WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance*

Welding parameters are for 75% Ar/25% CO2, at higher levels of argon the voltage should be decreased: 1-1 1/2 volts for 90% Ar/10% CO2.

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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