

Select 700GS

Carbon Steel / Self Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- SELECT 700GS is a carbon steel, flux cored electrode for use without an external shielding gas and should be welded with DCEN (straight polarity).
- The arc transfer is smooth and stable, with virtually no spatter emission. This "soft" arc transfer minimizes burn-through on thin gauge material.
- This slag system enables the electrode to weld in all positions and to make welds at high speed.
- Intended for welding thin-gauge carbon steel, ranging from 3/16 " to 22 gauge, applications are limited to single-pass weldments.
- This product is designed to weld quite effectively over galvanized material and can be used on certain aluminized surfaces as well.
- Select 700GS is an ideal choice for applications such as lap and butt welds on galvanized sheet metal, repair of automobile sheet metal, welding ductwork, and joining of galvanized roofing sheet metal.

CONFORMANCES

AWS A5.20

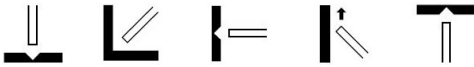
E71T1-14

E71T1-GS

DIAMETERS (in [mm])

0.030 (0.8), 0.035 (0.9), 0.045 (1.2), 1/16 (1.6), 0.068 (1.7)

POSITIONS



SHIELDING GAS

N/A

POLARITY

Direct Current Electrode Negative (DCEN)

TYPICAL MECHANICAL PROPERTIES

| Shielding Gas | Tensile Strength ksi (MPa) | Weld Condition | PWHT Temp |
|---------------|-------------------------------|----------------|-----------|
| N/A | 86 (596) | As-Welded | - |



Revision: 1/17/2025

Notice: Be sure to follow all your employers safety practices, policies and procedures when using this product. Refer to CSA W117.2 and ANSI Z49.1 Safety in Welding, Cutting and Allied Processes for further information and the manufactures SDS sheet. 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.

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RECOMMENDED WELDING PARAMETERS **

| Diameter in (mm) | Shielding Gas | Position | WFS* in/min (m/min) | Amps | Volts | CTWD* in (mm) |
|------------------|---------------|-------------------|---------------------|------|-------|---------------|
| 0.030 (0.8 mm) | N/A | Flat & Horizontal | 225 (5.7) | 100 | 16 | 1/2 (13) |
| | | Flat & Horizontal | 375 (9.5) | 150 | 17 | 1/2 (13) |
| | | Flat & Horizontal | 445 (11.3) | 175 | 17 | 1/2 (13) |
| | | All Positions | 80 (2.0) | 50 | 15 | 3/8 (10) |
| 0.035 (0.9 mm) | N/A | Flat & Horizontal | 110 (2.8) | 100 | 16 | 3/8 (10) |
| | | Flat & Horizontal | 180 (4.6) | 150 | 17 | 1/2 (13) |
| | | Flat & Horizontal | 305 (7.7) | 200 | 18 | 1/2 (13) |
| | | All Positions | 70 (1.8) | 75 | 15 | 3/8 (10) |
| 0.045 (1.2 mm) | N/A | All Positions | 70 (1.8) | 100 | 15 | 1/2 (13) |
| | | Flat & Horizontal | 120 (3.0) | 150 | 16 | 1/2 (13) |
| | | Flat & Horizontal | 195 (5.0) | 200 | 17 | 5/8 (16) |
| | | Flat & Horizontal | 245 (6.2) | 225 | 18 | 5/8 (16) |
| 1/16 (1.6 mm) | N/A | All Positions | 60 (1.5) | 150 | 17 | 1/2 (13) |
| | | Flat & Horizontal | 85 (2.2) | 200 | 18 | 1/2 (13) |
| | | Flat & Horizontal | 135 (3.4) | 250 | 18 | 5/8 (16) |
| | | Flat & Horizontal | 180 (4.6) | 300 | 19 | 3/4 (19) |
| 0.068 (1.7 mm) | N/A | All Positions | 55 (1.4) | 180 | 17 | 1/2 (13) |
| | | Flat & Horizontal | 80 (2.0) | 225 | 18 | 1/2 (13) |
| | | Flat & Horizontal | 125 (3.2) | 275 | 19 | 5/8 (16) |
| | | Flat & Horizontal | 175 (4.4) | 325 | 20 | 3/4 (19) |

* 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.

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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