

Select 701

Carbon Steel / Self Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Smooth arc transfer and exceptionally low spatter
- Ideal for applications where the use of shielding gas is not feasible and the impact toughness is not a primary concern.
- Well suited for butt, lap, and fillet welds on steels from 16 gauge through 1/2"
- A preheat of 325-375°F is recommended for welding materials from 3/8" to 1/2" thick.
- The .045" electrode is great for welding steels less than 3/8" thick, for thicker materials the 1/16" electrode is recommended.

CONFORMANCES

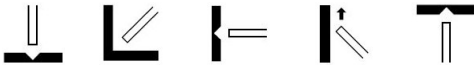
AWS A5.20

E71T-11-H8

DIAMETERS (in [mm])

0.030 (0.8), 0.035 (0.9), 0.045 (1.2), 1/16 (1.6), 0.068 (1.7), 5/64 (2.0)

POSITIONS



SHIELDING GAS

N/A

POLARITY

Direct Current Electrode Negative (DCEN)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Shielding Gas	Al	C	Mn	P	S	Si
N/A	1.43	0.23	0.34	0.008	0.003	0.13

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp
N/A	92 (636)	64 (439)	25	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.

600 Enterprise Drive, P.O. Box 259, Fort Loramie, Ohio 45845-0259 • 800-341-5215 • www.Select-Arc.com

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	3/8 - 1/2 (10 - 13)
		Flat & Horizontal	375 (9.5)	150	17	3/8 - 1/2 (10 - 13)
		Flat & Horizontal	445 (11.3)	175	17	3/8 - 1/2 (10 - 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 - 1/2 (10 - 13)
		Flat & Horizontal	180 (4.6)	150	17	3/8 - 1/2 (10 - 13)
		Flat & Horizontal	305 (7.7)	200	18	3/8 - 1/2 (10 - 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 - 3/4 (13 - 19)
		Flat & Horizontal	195 (5.0)	200	17	1/2 - 3/4 (13 - 19)
		Flat & Horizontal	245 (6.2)	225	18	1/2 - 3/4 (13 - 19)
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 - 3/4 (13 - 19)
		Flat & Horizontal	135 (3.4)	250	18	1/2 - 3/4 (13 - 19)
		Flat & Horizontal	180 (4.6)	300	19	1/2 - 3/4 (13 - 19)
0.068 (1.7 mm)	N/A	All Positions	60 (1.5)	175	17	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	85 (2.2)	225	18	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	125 (3.2)	275	19	5/8 - 1 (16 - 25)
		Flat & Horizontal	150 (3.8)	310	20	5/8 - 1 (16 - 25)
5/64 (2.0 mm)	N/A	All Positions	60 (1.5)	200	19	5/8 (16)
		Flat & Horizontal	80 (2.0)	250	20	5/8 - 1 (16 - 25)
		Flat & Horizontal	115 (2.9)	300	21	5/8 - 1 (16 - 25)
		Flat & Horizontal	120 (3.0)	325	21	5/8 - 1 (16 - 25)

* 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.

APPROVALS

Agency	Approval	Shielding Gas	Diameter(s) in (mm)
CWB CSA W48-23	E491T11-AZ-CS3-H8	N/A	0.035 (0.9) - 1/16 (1.6)

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.



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.