

Select 70C-10B

Carbon Steel / Gas Shielded / Metal Cored

PRODUCT DATA SHEET

FEATURES

- Designed for high-speed welding of thin gauge carbon steels.
- Intended to use with shielding gas blends of 100% CO₂ as well as 75-95% Ar/balance CO₂.
- Travel speeds of 85-100 ipm are readily achievable.
- Performance of this product is not dependent on high technology power sources; a standard CV machine produces excellent results.
- Welding automotive and truck frames, automotive cradle assemblies, water heater tanks, farm machinery and other general-purpose welding of light gauge components.

CONFORMANCES

AWS A5.18

E70C-6C

E70C-6M

ASME SFA 5.18

E70C-6C

E70C-6M

DIAMETERS (in [mm])

0.045 (1.2), 0.052 (1.3), 1/16 (1.6), 5/64 (2.0), 3/32 (2.4)

POSITIONS



SHIELDING GAS

100% CO₂, 75% Ar / 25% CO₂

Flow Rate: 40 - 50 CFH

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Shielding Gas	C	Cr	Cu	Mn	Mo	Ni	P	S	Si	V
100%CO ₂	0.03	0.05	0.03	1.38	0.00	0.02	0.013	0.010	0.50	0.00
75%Ar / 25%CO ₂	0.04	0.05	0.03	1.67	0.00	0.02	0.011	0.010	0.83	0.00

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp	CVN @ -20°F (-30°C) ft-lb (J)
100%CO ₂	82 (566)	69 (476)	30	As-Welded	-	40 (54)
75%Ar / 25%CO ₂	90 (621)	80 (552)	28	As-Welded	-	43 (58)



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.

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	75% Ar/25% CO2	Flat & Horizontal	260 (6.6)	200	25	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	305 (7.7)	220	26	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	360 (9.1)	240	27.5	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	405 (10.3)	255	29	5/8 - 3/4 (16 - 19)
0.052 (1.3 mm)	75% Ar/25% CO2	Flat & Horizontal	235 (6.0)	215	25	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	315 (8.0)	260	26	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	330 (8.4)	275	27.5	3/4 - 1 (19 - 25)
		Flat & Horizontal	345 (8.8)	295	29	3/4 - 1 (19 - 25)
1/16 (1.6 mm)	75% Ar/25% CO2	Flat & Horizontal	200 (5.1)	250	25	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	245 (6.2)	290	26	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	275 (7.0)	310	27.5	3/4 - 1 (19 - 25)
		Flat & Horizontal	285 (7.2)	330	29	3/4 - 1 (19 - 25)
5/64 (2.0 mm)	75% Ar/25% CO2	Flat & Horizontal	170 (4.3)	350	25	3/4 - 1 (19 - 25)
		Flat & Horizontal	185 (4.7)	370	26	3/4 - 1 (19 - 25)
		Flat & Horizontal	210 (5.3)	400	28	1 - 1 1/4 (25 - 32)
		Flat & Horizontal	255 (6.5)	415	29	1 - 1 1/4 (25 - 32)
3/32 (2.4 mm)	75% Ar/25% CO2	Flat & Horizontal	125 (3.2)	370	25	3/4 - 1 (19 - 25)
		Flat & Horizontal	140 (3.6)	390	26	3/4 - 1 (19 - 25)
		Flat & Horizontal	160 (4.1)	425	28	1 - 1 1/4 (25 - 32)
		Flat & Horizontal	185 (4.7)	450	29	1 - 1 1/4 (25 - 32)

* 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.

For Welding in 100% CO2, Increase by 1 - 1.5 volts

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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