

# Select 70C-3

Carbon Steel / Gas Shielded / Metal Cored

PRODUCT DATA SHEET

## FEATURES

- Manganese and silicon content are lower than the 70C-6M product, providing lower tensile strength
- Arc transfer is a small droplet, smooth spray
- Can be used to weld on hot rolled, oxidized steel with virtually no lack of fusion
- Minimal slag islands on finished weld deposits

## CONFORMANCES

AWS A5.18

E70C-3M

## DIAMETERS (in [mm])

0.045 (1.2)

## POSITIONS



## SHIELDING GAS

75-80% Ar / Balance CO<sub>2</sub>, 95%Ar / 5% CO<sub>2</sub>

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
75%Ar / 25%CO <sub>2</sub>	0.04	0.05	0.05	1.32	0.002	0.02	0.010	0.011	0.42	0.003

## TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp	CVN @ 0°F (-20°C) ft-lb (J)
75%Ar / 25%CO <sub>2</sub>	81 (559)	73 (503)	25	As-Welded	-	57 (77)
95%Ar / 5%CO <sub>2</sub>	86 (596)	76 (523)	24	As-Welded	-	53 (72)

## 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% CO <sub>2</sub>	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)

\* 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.

Welding parameters are for 75% Ar /25% CO<sub>2</sub>, at higher levels of argon the voltage should be decreased: 1-2 volts for 95% Ar/5% CO<sub>2</sub>.



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.

## **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.



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 • 877-869-4009 • [www.Select-SAI.com](http://www.Select-SAI.com)**