

# Select 70C-6 ZN

Carbon Steel / Gas Shielded / Metal Cored

PRODUCT DATA SHEET

## FEATURES

- Select 70C-6 ZN is a premier carbon steel, composite metal cored electrode designed to produce a highly stable arc through CV and Pulse parameters.
- Ideal for thin galvanized materials and bare carbon steel components which require spatter free surfaces and defect free welds with good sidewall fusion.
- Very low diffusible hydrogen levels, less than 4.0mL/100g.
- High travel speeds of 80 inches per minute are realized over coated and bare carbon steels with a stable arc, fine spray transfer with minimal spatter.
- Applications are limited to single-pass weldments.

## CONFORMANCES

AWS A5.18

E70C-GSM-H4

ASME SFA 5.18

E70C-GSM-H4

## DIAMETERS [in (mm)]

0.035 (0.9), 0.045 (1.2), 0.052 (1.3)

## POSITIONS



## SHIELDING GAS

75% Ar / 25% CO<sub>2</sub>

Flow Rate: 40 - 50 CFH

## POLARITY

Direct Current Electrode Positive (DCEP)

## TYPICAL MECHANICAL PROPERTIES

| Shielding Gas              | Tensile Strength<br>ksi (MPa) | Weld Condition | PWHT Temp |
|----------------------------|-------------------------------|----------------|-----------|
| 75%Ar / 25%CO <sub>2</sub> | 84 (576)                      | As-Welded      | -         |



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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<br>in (mm) | Shielding Gas  | Position          | WFS*<br>in/min (m/min) | Amps | Volts | CTWD*<br>in (mm)    |
|---------------------|----------------|-------------------|------------------------|------|-------|---------------------|
| 0.035 (0.9 mm)      | 75% Ar/25% CO2 | Flat & Horizontal | 345 (8.8)              | 170  | 25    | 1/2 - 5/8 (13 - 16) |
|                     |                | Flat & Horizontal | 425 (10.8)             | 190  | 26    | 1/2 - 5/8 (13 - 16) |
|                     |                | Flat & Horizontal | 475 (12.1)             | 210  | 27.5  | 5/8 - 3/4 (16 - 19) |
|                     |                | Flat & Horizontal | 570 (14.5)             | 225  | 29    | 5/8 - 3/4 (16 - 19) |
| 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)   |

\* 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)<br>in (mm)   |
|----------------------|----------|---------------|--------------------------|
| Chrysler MS-90024/05 | W503     | 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.



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