

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% CO₂

Flow Rate: 40 - 50 CFH

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL MECHANICAL PROPERTIES

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



Revision: 11/20/2025

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)
0.035 (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) 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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