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.

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%CO2	84 (576)	As-Welded	-

CONFORMANCES

AWS A5.18	E70C-GSM-H4
ASME SFA 5.18	E70C-GSM-H4

Revision: 11/20/2025

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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