

Select 70C-6LS

Carbon Steel / Gas Shielded / Metal Cored

PRODUCT DATA SHEET

FEATURES

- Designed to produce cleaner weld deposits, with minimal slag islands, than conventional metal cored electrodes
- Minimizing slag islands and spatter requires less cleanup when multiple beads are to be deposited.
- Arc transfer is a stable, fine droplet spray
- Ideal for welding structural steel, thin plate fabrication, general fabrication, and welding of thin walled tanks.
- Intended for welding carbon steels such as ASTM A36, A285, A515-Gr 70, A516-Gr 70 and A572

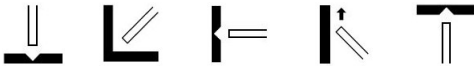
CONFORMANCES

AWS A5.18	E70C-6M-H4
AWS A5.36	E70T15-M20A2-CS1-H4 E70T15-M21A2-CS1-H4
AWS D1.8	0.052 in (1.3 mm), (90% Ar/10% CO2) 1/16 in (1.6 mm), (75% Ar/25% CO2) 1/16 in (1.6 mm), (90% Ar/10% CO2)

DIAMETERS (in [mm])

0.035 (0.9), 0.045 (1.2), 0.052 (1.3), 1/16 (1.6), 5/64 (2.0)

POSITIONS



SHIELDING GAS

75-95%Ar/Balance 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
75%Ar / 25%CO2	0.04	0.04	0.04	1.58	0.01	0.37	0.01	0.01	0.59	0.00
85%Ar / 15%CO2	0.05	0.03	0.03	1.62	0.01	0.36	0.01	0.01	0.67	0.00
90%Ar / 10%CO2	0.04	0.06	0.03	1.64	0.01	0.37	0.01	0.01	0.67	0.00
92%Ar / 8%CO2	0.04	0.04	0.03	1.66	0.01	0.36	0.01	0.01	0.67	0.01

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)
75%Ar / 25%CO2	85 (586)	70 (483)	30	As-Welded	-	42 (57)
85%Ar / 15%CO2	85 (586)	71 (490)	28	As-Welded	-	40 (54)
90%Ar / 10%CO2	89 (614)	75 (517)	27	As-Welded	-	53 (72)
92%Ar / 8%CO2	91 (628)	78 (538)	27	As-Welded	-	36 (49)



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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)
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)

* 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.

At higher levels of argon the voltage should be gradually decreased; 1/2-1 volt for 85% Ar/15% CO2, 1-1 1/2 volts for 90% Ar/10% CO2 and 1-2 volts for 95% Ar/5% CO2.

APPROVALS

Agency	Approval	Shielding Gas	Diameter(s) in (mm)
ABS	3YSA	M21 (75%Ar / 25%CO2)	0.045 (1.2) - 1/16 (1.6)
CWB CSA W48-23	E491T15-M21A3-CS1-H4	M21 (75%Ar / 25%CO2)	0.035 (0.9) - 1/16 (1.6)
	E491T15-M20A3-CS1-H4	M20 (92%Ar / 8%CO2)	0.035 (0.9) - 1/16 (1.6)
	E491T15-GA3-CS1-H4	M14 (Arcal 14)	0.035 (0.9) - 1/16 (1.6)
		G (Gas Mixture*)	0.035 (0.9) - 1/16 (1.6)

* G - Gas mixtures containing components not listed, or mixtures outside the composition range listed in AWS A5.32 (ISO 14175). Two gas mixtures with the same G - classification may not be interchangeable. For more details see approval website or contact Select-SAI.

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.



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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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