Select 70TR

Carbon Steel / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- This product is designed to produced perfectly flat horizontal, equal legged fillets, with no double bead effect.
- Beads can be “stacked” in a horizontal fillet with no drooping or roll on the bead surface.
- Ideal for those structural welds or general fabrications where bead geometry and cosmetics are of primary importance.

DIAMETERS (in (mm))

1/16 (1.6), 5/64 (2.0), 3/32 (2.4)

POSITIONS

SHIELDING GAS

75-80%Ar/Balance CO2, 100% CO2
Flow Rate: 40 - 50 CFM

POLARITY

Direct Current Electrode Positive (DCEP)

CONFORMANCES

AWS A5.20	E70T-1C-H8
	E70T-1M-H8
	E70T-9C-H8
	E70T-9M-H8
AWS A5.36	E70T1-C1A2-CS1-H8
	E70T1-M21A2-CS1-H8
ASME SFA 5.20	E70T-1C-H8
	E70T-1M-H8
	E70T-9C-H8
	E70T-9M-H8
AWS D1.8	1/16 in (1.6 mm), (100% CO2)
	1/16 in (1.6 mm), (75% Ar/25% CO2)
	3/32 in (2.4 mm), (100% CO2)
	3/32 in (2.4 mm), (75% Ar/25% CO2)
	5/64 in (2.0 mm), (100% CO2)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Shielding Gas	C	Mn	P	S	Si
100%CO2	0.06	1.56	0.006	0.010	0.58
75%Ar / 25%CO2	0.06	1.68	0.007	0.009	0.70

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)	CVN @ -20°F (-30°C) ft-lb (J)
100%CO2	89 (614)	74 (510)	26	As-Welded	-	43 (58)	35 (47)
75%Ar / 25%CO2	94 (648)	81 (559)	24	As-Welded	-	30 (41)	24 (33)

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RECOMMENDED WELDING PARAMETERS

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	100% CO2	Flat & Horizontal	250 (6.4)	175	24	5/8 (16)
		Flat & Horizontal	340 (8.6)	205	27	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	440 (11.2)	235	29	5/8 - 3/4 (16 - 19)
1/16 (1.6 mm)	100% CO2	Flat & Horizontal	235 (6.0)	245	24	3/4 (19)
		Flat & Horizontal	280 (7.1)	275	27	3/4 - 1 (19 - 25)
		Flat & Horizontal	325 (8.3)	320	29	3/4 - 1 (19 - 25)
5/64 (2.0 mm)	100% CO2	Flat & Horizontal	145 (3.7)	280	25	1 (25)
		Flat & Horizontal	190 (4.8)	320	27	1 - 1 1/4 (25 - 32)
		Flat & Horizontal	230 (5.8)	365	29	1 - 1 1/4 (25 - 32)
3/32 (2.4 mm)	100% CO2	Flat & Horizontal	120 (3.0)	275	25	1 1/4 (32)
		Flat & Horizontal	150 (3.8)	335	27	1 1/4 - 1 1/2 (32 - 38)
		Flat & Horizontal	165 (4.2)	400	29	1 1/4 - 1 1/2 (32 - 38)

** WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance*

For 75-80% Ar/Balance CO2, reduce the voltage by 1 to 1.5 volts.

APPROVALS

Agency	Approval	Shielding Gas	Diameter(s) in (mm)
ABS	E70T-1C	C1 (100%CO2)	1/16 (1.6) - 3/32 (2.4)
CWB CSA W48-23	E490T1-C1A3-CS1-H8	C1 (100%CO2)	0.045 (1.2) - 3/32 (2.4)
	E490T1-M21A3-CS1-H8 (E492T-9M-H8)	M21 (75%Ar / 25%CO2)	0.045 (1.2) - 3/32 (2.4)

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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