

Select 717

Carbon Steel / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Designed to operate with high argon blends of 75-95% Argon/balance CO₂
- Spatter is nearly eliminated with the high argon blends employed with this product
- Arc transfer is a small droplet, spray-like mode
- Intended for single and multiple pass welding of most carbon steels, such as ASTM A36, A285, A515-Gr 70, and A516-Gr 70
- Ideal for light gauge, as well as standard plate fabrication and structural steel welding
- Typical applications include rail cars, structural steel, and applications involving light gauge steels

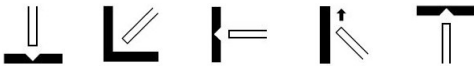
CONFORMANCES

AWS A5.20	E71T-1M-H8 E71T-9M-H8
ASME SFA 5.20	E71T-1M-H8
AWS A5.36	E71T1-M20A2-CS2-H8 E71T1-M21A2-CS2-H8

DIAMETERS (in (mm))

0.045 (1.2), 0.052 (1.3), 1/16 (1.6)

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%CO ₂	0.04	0.07	0.05	0.96	0.00	0.32	0.010	0.010	0.45	0.02
95%Ar / 5%CO ₂	0.04	0.05	0.02	1.12	0.01	0.37	0.007	0.010	0.59	0.02

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)
75%Ar / 25%CO ₂	83 (572)	70 (483)	27	As-Welded	-	76 (103)	55 (75)
95%Ar / 5%CO ₂	88 (607)	76 (524)	26	As-Welded	-	97 (132)	89 (121)



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.

RECOMMENDED WELDING PARAMETERS **

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	90% Ar/10% CO2	All Positions	235 (6.0)	160	22	1/2 - 5/8 (13 - 16)
		All Positions	300 (7.6)	185	24	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	375 (9.5)	215	25	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	430 (10.9)	235	27	5/8 - 3/4 (16 - 19)
0.052 (1.3 mm)	90% Ar/10% CO2	All Positions	170 (4.3)	155	22	5/8 - 3/4 (16 - 19)
		All Positions	200 (5.1)	175	23	5/8 - 3/4 (16 - 19)
		All Positions	260 (6.6)	225	24	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	310 (7.9)	250	25	3/4 - 1 (19 - 25)
1/16 (1.6 mm)	90% Ar/10% CO2	Flat & Horizontal	385 (9.8)	280	27	3/4 - 1 (19 - 25)
		All Positions	125 (3.2)	165	22	5/8 - 3/4 (16 - 19)
		All Positions	150 (3.8)	195	23	5/8 - 3/4 (16 - 19)
		All Positions	180 (4.6)	225	24	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	265 (6.7)	280	25	3/4 - 1 (19 - 25)
		Flat & Horizontal	305 (7.7)	320	27	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.

For shielding gas with higher amounts of CO2, voltage may need to be increased 1 to 2.5 volts

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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