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 CFM

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	0.07	0.05	0.96	0.00	0.32	0.010	0.010	0.45	0.02
95%Ar / 5%CO2	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%CO2	83 (572)	70 (483)	27	As-Welded	-	76 (103)	55 (75)
95%Ar / 5%CO2	88 (607)	76 (524)	26	As-Welded	-	97 (132)	89 (121)

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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)	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)
		Flat & Horizontal	385 (9.8)	280	27	3/4 - 1 (19 - 25)
1/16 (1.6 mm)	90% Ar/10% CO2	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*

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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