Select 71T-HYD

Carbon Steel / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Intended for single and multiple pass welding of carbon steels, such as ASTM A36, A131, and A285
- Designed for use with 100% CO2 shielding gas
- Developed primarily to meet the strict criteria of the classification MIL-71T-HYD per MIL-DTL-24403/1F, which includes high and low heat input properties in both the as welded and post weld heat treated conditions

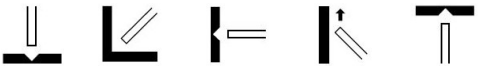
CONFORMANCES

MILITARY MIL-DTL-24403/1F	MIL-71T-1-HYD
ASME SFA 5.20	E71T-1C-H8
	E71T-9C-H8
AWS A5.20	E71T-1C-H8
	E71T-9C-H8

DIAMETERS (in (mm))

0.045 (1.2), 0.052 (1.3)

POSITIONS



SHIELDING GAS

100% 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
100%CO2	0.06	0.05	0.03	1.50	0.00	0.45	0.006	0.007	0.37	0.02

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)	CVN @ -40°F (-40°C) ft-lb (J)
100%CO2	94 (650)	85 (586)	26	As-Welded	-	51 (69)	37 (50)

Revision: 1/17/2025

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)
0.045 (1.2 mm)	100% CO2	All Positions	200 (5.1)	145	23	1/2 - 5/8 (13 - 16)
		All Positions	235 (6.0)	160	24	1/2 - 5/8 (13 - 16)
		All Positions	300 (7.6)	185	26	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	375 (9.5)	215	27	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	440 (11.2)	235	29	5/8 - 3/4 (16 - 19)
0.052 (1.3 mm)	100% CO2	All Positions	150 (3.8)	120	21	5/8 - 3/4 (16 - 19)
		All Positions	200 (5.1)	175	23	5/8 - 3/4 (16 - 19)
		All Positions	250 (6.4)	225	25	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	310 (7.9)	250	27	3/4 - 1 (19 - 25)
		Flat & Horizontal	395 (10.0)	280	28	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.*

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.

Revision: 1/17/2025

600 Enterprise Drive, P.O. Box 259, Fort Loramie, Ohio 45845-0259 • 800-341-5215 • www.Select-Arc.com