

Select 720

Carbon Steel / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Designed for ease of welding in all positions.
- Arc transfer is soft; resides on the puddle in a small to medium droplet transfer.
- Mechanical properties exceed the minimum AWS requirements and rival E7018 electrodes.
- Intended for use with 100% CO₂ or 75-80% Ar/balance CO₂.
- Excels in general fabrication, structural steel, and shipbuilding applications.
- Although a dual gas electrode, it is optimized for use on 75-80% Ar/balance CO₂.

CONFORMANCES

AWS A5.20

E71T-1C-H8

E71T-1M-H8

E71T-9C-H8

E71T-9M-H8

AWS A5.36

E71T1-C1A2-CS1-H8

E71T1-M21A2-CS1-H8

ASME SFA 5.20

E71T-1C-H8

E71T-1M-H8

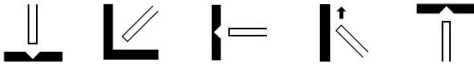
E71T-9C-H8

E71T-9M-H8

DIAMETERS (in [mm])

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

POSITIONS



AWS D1.8

0.045 in (1.2 mm), (100% CO₂)

0.045 in (1.2 mm), (75% Ar/25% CO₂)

0.052 in (1.3 mm), (100% CO₂)

0.052 in (1.3 mm), (75% Ar/25% CO₂)

1/16 in (1.6 mm), (100% CO₂)

1/16 in (1.6 mm), (75% Ar/25% CO₂)

SHIELDING GAS

75-80% Ar/Balance CO₂, 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%CO ₂	0.04	0.05	0.04	1.18	0.01	0.01	0.015	0.010	0.50	0.02
75%Ar / 25%CO ₂	0.04	0.06	0.03	1.46	0.00	0.02	0.016	0.010	0.55	0.01

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%CO ₂	86 (593)	77 (531)	27	As-Welded	-	80 (108)	69 (94)
75%Ar / 25%CO ₂	93 (641)	84 (579)	26	As-Welded	-	95 (129)	74 (100)



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.

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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)	100% CO2	All Positions	275 (7.0)	120	23	1/2 - 5/8 (13 - 16)
		All Positions	320 (8.1)	135	24	1/2 - 5/8 (13 - 16)
		All Positions	420 (10.7)	160	26	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	465 (11.8)	180	27	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	570 (14.5)	200	29	5/8 - 3/4 (16 - 19)
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	170 (4.3)	155	23	5/8 - 3/4 (16 - 19)
		All Positions	200 (5.1)	175	24	5/8 - 3/4 (16 - 19)
		All Positions	250 (6.4)	225	26	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	310 (7.9)	250	27	3/4 - 1 (19 - 25)
		Flat & Horizontal	395 (10.0)	280	29	3/4 - 1 (19 - 25)
1/16 (1.6 mm)	100% CO2	All Positions	125 (3.2)	165	23	5/8 - 3/4 (16 - 19)
		All Positions	150 (3.8)	195	24	5/8 - 3/4 (16 - 19)
		All Positions	185 (4.7)	225	26	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	265 (6.7)	280	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	All Positions	100 (2.5)	195	23	3/4 (19)
		All Positions	110 (2.8)	210	24	3/4 (19)
		All Positions	130 (3.3)	240	26	3/4 (19)
		Flat & Horizontal	200 (5.1)	310	27	1 - 1 1/4 (25 - 32)
		Flat & Horizontal	225 (5.7)	350	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.

For 75-80%Ar-Balance CO2 shielding gas, decrease voltage by 1 to 1.5 volts



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APPROVALS

Agency	Approval	Shielding Gas	Diameter(s) in (mm)
ABS	3YSA	C1 (100%CO2)	0.035 (0.9) - 1/16 (1.6)
		M21 (75%Ar / 25%CO2)	0.035 (0.9) - 1/16 (1.6)
CWB CSA W48-23	E491T1-C1A3-CS1-H4	C1 (100%CO2)	0.035 (0.9) - 5/64 (2.0)
	E491T1-M21A3-CS1-H4	M21 (75%Ar / 25%CO2)	0.035 (0.9) - 5/64 (2.0)
	E491T1-M20A3-CS1-H4	M20 (85%Ar / 15%CO2)	0.035 (0.9) - 5/64 (2.0)
	E491T1-GA3-CS1-H4	G (Gas Mixture*)	0.035 (0.9) - 5/64 (2.0)
DNV	III YMS	M21 (75%Ar / 25%CO2)	0.035 (0.9) - 1/16 (1.6)
		C1 (100%CO2)	0.035 (0.9) - 1/16 (1.6)
LLOYDS	3YS (H10)	M21 (75%Ar / 25%CO2)	0.035 (0.9) - 1/16 (1.6)
		C1 (100%CO2)	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.

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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