# Select 721 Mil

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 shielding with blends of 75-80% Ar/balance CO2
- The higher argon blends offer lower fume generation rates than shielding with carbon dioxide
- Developed primarily for Naval shipbuilding applications

#### CONFORMANCES

MIL-71T-1-HYM MILITARY MIL-DTL-24403/1F

E71T-12M **ASME SFA 5.20** E71T-1M

E71T-9M

E71T-12M **AWS A5.20** 

E71T-1M

E71T-9M

**AWS A5.36** E71T1-M21A2-CS2

E71T1-M21P2-CS2

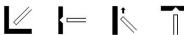
# **DIAMETERS (in (mm))**

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

#### **POSITIONS**











### SHIELDING GAS

75% Ar / 25% CO2 Flow Rate: 40 - 50 CFH

## **POLARITY**

Direct Current Electrode Positive (DCEP)

# **TYPICAL WELD DEPOSIT CHEMISTRY (WT%)**

Shielding Gas	С	Cr	Cu	Mn	Мо	Ni	P	S	Si	V
75%Ar / 25%CO2	0.04	0.06	0.03	1.19	0.00	0.41	0.012	0.007	0.28	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)	76 (524)	28	As-Welded	-	105 (142)	81 (110)
75%Ar / 25%CO2	83 (572)	71 (490)	30	PWHT	1150°F for 2 hrs	98 (133)	57 (77)



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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)	75% Ar/25% 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)	75% Ar/25% 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)
		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)
1/16 (1.6 mm)	75% Ar/25% CO2	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)

## 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

### 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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<sup>\*</sup> 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 "allposition" 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.

<sup>\*</sup>Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.