

Select 72

Carbon Steel / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Spatter levels are low with easily detachable slag and excellent bead profile.
- Intended for applications involving weldments over mill scale, rust, or other mild contaminants.
- Typically used for general steel plate fabrication.
- Uses a rutile based slag system and welds with a quasi-spray transfer.

CONFORMANCES

AWS A5.20

E70T-2C

DIAMETERS (in [mm])

5/64 (2.0), 3/32 (2.4), 7/64 (2.8)

POSITIONS



SHIELDING GAS

100% CO₂

Flow Rate: 40 - 50 CFM

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Weld Condition	PWHT Temp
100%CO ₂	85 (586)	As-Welded	-

RECOMMENDED WELDING PARAMETERS

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
5/64 (2.0 mm)	100% CO ₂	Flat & Horizontal	145 (3.7)	280	25	1 (25)
		Flat & Horizontal	190 (4.8)	320	27	1 - 1 1/4 (25 - 32)
		Flat & Horizontal	230 (5.8)	365	29	1 - 1 1/4 (25 - 32)
3/32 (2.4 mm)	100% CO ₂	Flat & Horizontal	120 (3.0)	275	25	1 1/4 (32)
		Flat & Horizontal	150 (3.8)	335	27	1 1/4 - 1 1/2 (32 - 38)
		Flat & Horizontal	165 (4.2)	400	29	1 1/4 - 1 1/2 (32 - 38)
7/64 (2.8 mm)	100% CO ₂	Flat & Horizontal	95 (2.4)	320	25	1 1/4 (32)
		Flat & Horizontal	115 (2.9)	370	27	1 1/4 - 1 1/2 (32 - 38)
		Flat & Horizontal	120 (3.0)	420	29	1 1/4 - 1 1/2 (32 - 38)

* WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance



Revision: 9/28/2022

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.

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

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: 9/28/2022

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.

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