

Select 74

Carbon Steel / Self Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- This electrode is intended for flat position welding of grooves and fillets and horizontal fillet welding with extremely high deposition rates.
- The highly basic slag minimizes hot cracking on steels high in sulfur.
- Slag detachment is quite good, and the bead profile is slightly convex.
- Typical applications are light gauge steel plate fabrication or general purpose fabrication of carbon steels.
- Select 74 is also a good choice in poor fit up situations or when extended stickouts must be used in hard-to-reach areas.

CONFORMANCES

AWS A5.20

E70T-4

ASME SFA 5.20

E70T-4

DIAMETERS (in [mm])

1/16 (1.6), 5/64 (2.0), 3/32 (2.4), 0.120 (3.0)

POSITIONS



SHIELDING GAS

N/A

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Shielding Gas	Al	C	Mn	P	S	Si
N/A	1.59	0.20	0.50	0.008	0.003	0.17

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp
N/A	88 (607)	65 (448)	28	As-Welded	-



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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.

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)
1/16 (1.6 mm)	N/A	Flat & Horizontal	150 (3.8)	170	27	1 - 1 1/2 (25 - 38)
		Flat & Horizontal	200 (5.1)	200	28	1 - 1 1/2 (25 - 38)
		Flat & Horizontal	300 (7.6)	290	30	1 - 1 1/2 (25 - 38)
5/64 (2.0 mm)	N/A	Flat & Horizontal	150 (3.8)	240	28	2 - 3 (51 - 76)
		Flat & Horizontal	220 (5.6)	310	29	2 - 3 (51 - 76)
		Flat & Horizontal	300 (7.6)	335	31	2 - 3 (51 - 76)
3/32 (2.4 mm)	N/A	Flat & Horizontal	125 (3.2)	270	28	2 1/2 - 3 (64 - 76)
		Flat & Horizontal	150 (3.8)	310	29	2 1/2 - 3 (64 - 76)
		Flat & Horizontal	175 (4.4)	340	30	2 1/2 - 3 (64 - 76)
0.120 (3.0 mm)	N/A	Flat & Horizontal	125 (3.2)	350	26	3 - 3 1/2 (76 - 89)
		Flat & Horizontal	150 (3.8)	390	28	3 - 3 1/2 (76 - 89)
		Flat & Horizontal	175 (4.4)	425	31	3 - 3 1/2 (76 - 89)

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

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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