

Select 71A

Carbon Steel / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Arc transfers in a small droplet spray, with improved stability at lower currents.
- The slag is typically self-peeling and removes very cleanly.
- Intended for steels such as ASTM A36, A285, A515-Grade 70, and A516-Grade 70.
- Well suited for structural welding, general fabrication, welding rail cars and construction machinery, and welding earthmoving machinery.

CONFORMANCES

| | |
|----------------------|--------------------------|
| AWS A5.20 | E70T-1C-H8 E70T-9C-H8 |
| ASME SFA 5.20 | E70T-1C-H8 E70T-9C-H8 |
| AWS A5.36 | E70T1-C1A2-CS1-H8 |

DIAMETERS (in [mm])

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

POSITIONS



SHIELDING GAS

100% CO₂
Flow Rate: 40 - 50 CFM

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

| Shielding Gas | C | Mn | P | S | Si |
|---------------------|------|------|-------|-------|------|
| 100%CO ₂ | 0.06 | 1.28 | 0.008 | 0.011 | 0.54 |

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 | 88 (607) | 74 (510) | 23 | As-Welded | - | 32 (43) | 21 (28) |



Revision: 9/16/2022

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.

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RECOMMENDED WELDING PARAMETERS

| Diameter in (mm) | Shielding Gas | Position | WFS* in/min (m/min) | Amps | Volts | CTWD* in (mm) |
|------------------|---------------|-------------------|---------------------|------|-------|-------------------------|
| 1/16 (1.6 mm) | 100% CO2 | Flat & Horizontal | 235 (6.0) | 245 | 24 | 3/4 (19) |
| | | Flat & Horizontal | 280 (7.1) | 275 | 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 | 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% CO2 | 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) |

* 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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