

Select 71T-HYN

Carbon Steel / Gas Shielded / Flux Cored

PRODUCT DATA SHEET

FEATURES

- Designed for ease of welding in all positions
- Mechanical properties exceed the minimum AWS requirements
- Intended for use with 75-80% Ar/balance CO₂ shielding gas
- Excels in general fabrication, structural steel, and shipbuilding applications
- Developed primarily to meet the strict criteria of the classification MIL-71T-HYN per MIL-DTL-24403/1F, which includes high and low heat input properties in both the as welded and post weld heat treated conditions

CONFORMANCES

ASME SFA 5.20

E71T-1M-H8

E71T-9M-H8

AWS A5.20

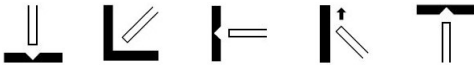
E71T-1M-H8

E71T-9M-H8

DIAMETERS (in [mm])

0.045 (1.2), 0.052 (1.3)

POSITIONS



SHIELDING GAS

75% Ar / 25% CO₂

Flow Rate: 40 - 50 CFM

POLARITY

Direct Current Electrode Positive (DCEP)

TYPICAL WELD DEPOSIT CHEMISTRY (WT%)

Shielding Gas	C	Cr	Cu	Mn	Mo	Ni	P	S	Si	V
75%Ar / 25%CO ₂	0.05	0.03	0.02	1.35	0.00	0.41	0.006	0.006	0.32	0.02

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp	CVN @ -20°F (-30°C) ft-lb (J)	CVN @ -40°F (-40°C) ft-lb (J)
75%Ar / 25%CO ₂	89 (614)	81 (559)	28	As-Welded	-	80 (108)	39 (53)



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	22	1/2 - 5/8 (13 - 16)
		All Positions	235 (6.0)	160	23	1/2 - 5/8 (13 - 16)
		All Positions	300 (7.6)	185	25	1/2 - 5/8 (13 - 16)
		Flat & Horizontal	375 (9.5)	215	26	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	440 (11.2)	235	28	5/8 - 3/4 (16 - 19)
0.052 (1.3 mm)	75% Ar/25% CO2	All Positions	150 (3.8)	120	20	5/8 - 3/4 (16 - 19)
		All Positions	200 (5.1)	175	22	5/8 - 3/4 (16 - 19)
		All Positions	250 (6.4)	225	24	5/8 - 3/4 (16 - 19)
		Flat & Horizontal	310 (7.9)	250	25	3/4 - 1 (19 - 25)
		Flat & Horizontal	395 (10.0)	280	27	3/4 - 1 (19 - 25)

* 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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