



## Select 71A

### Description:

**Select 71A** is a carbon steel electrode for flux cored arc welding with external gas shielding. It is intended for single and multiple pass welding of carbon, and certain low alloy, steels in the flat and horizontal fillet positions. This electrode is designed for use with carbon dioxide shielding gas. Gas flow rates should be maintained at 35-50 cfh. Dew point of the gas must be at least -40°F.

### Classifications & Approvals:

- E70T-1C, E70T-9C per AWS A5.20, SFA 5.20.

### Characteristics:

**Select 71A** is a general purpose E70T-1C electrode with extremely high welder appeal. It has a stable arc transfer, with low spatter, over a broad amperage range, performing well at both the high and low ends of the range. This wire has excellent wetting characteristics, resulting in a superior bead shape. The slag is typically self peeling. The high level of deoxidation facilitates welding over mill scale, rust, and other mild contaminants on the plate.

### Applications:

**Select 71A** is ideal for those applications involving the welding of structural carbon steels, where high deposition rates and superior penetration characteristics are preferred. It may be used for welding steels such as A36, A285, A515, and A516.

### Typical Mechanical Properties (100CO<sub>2</sub>):

Ultimate Tensile Strength (psi)	88,000
Yield Strength (psi)	74,000
Percent Elongation	23
CVN (ft•lb f) @ 0°F	32
@-20° F	21

### Typical Deposit Composition:

Wt%	C	Mn	Si	P	S
	.06	1.28	.54	.008	.011

### Recommended Welding Parameters:

Diam.	Optimum			Optimum			ESO
	Amps	Volts	WFS	Amps	Volts	WFS	
1/8"	500	29	110	375-725	28/37	65-175	1"-1¼"
7/64"	475	29	140	350-700	27/36	80-250	1"-1¼"
3/32"	425	29	180	300-550	26/34	110-270	¾"-1¼"
5/64"	390	29	250	280-430	26/33	140-300	¾"-1¼"
1/16"	330	29	330	150-400	24/34	130-500	¾"-1"

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Notice: 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.