

DUAL SHIELD 710X-M

MILD STEEL
FLUX CORED WIRES

Tech Data Sheet



Dual Shield 710X-M is an all-position flux cored wire for general purpose welding. It provides outstanding operator appeal with an easily controlled arc, improved operation at both lower and higher current levels, minimal spatter and easily removed slag. Dual Shield 710X-M is designed to be used with 75/25 Argon CO₂ gas mix, however pure CO₂ may also be used.

TYPICAL MECHANICAL PROPERTIES

Shielding Gas	AS WELDED		AS WELDED	
	75/25		CO ₂	
Yield Strength, ksi (MPa)	74	510	68	470
Tensile Strength, ksi (MPa)	83	570	77	530
% Elongation (in 2", 51mm)	29		30	

TYPICAL CHARPY V-NOTCH IMPACT PROPERTIES

Shielding Gas	FT.-LBS. (J)		FT.-LBS. (J)	
	75/25		CO ₂	
Testing Temperature				
0°F (-18°C)	72	97	60	81
-20°F (-29°C)	56	76	33	45

TYPICAL UNDILUTED WELD METAL ANALYSIS (%)

Shielding Gas	75/25	CO ₂
Carbon	0.04	0.04
Manganese	1.3	1.0
Silicon	0.5	0.3
Phosphorus	0.012	0.012
Sulfur	0.008	0.008

TYPICAL WELDING RANGE - Vertical Up

Wire Feed Speed	Low		High		
	75/25		CO ₂		
.045"	150	450	160	400	
.052"	125	400	160	250	
1/16"	98	250	98	250	
Volts	.045"	19.0	26.5	21.0	27.5
	.052"	20.0	26.5	21.0	26.5
	1/16"	20.0	26.5	20.0	26.5
	Amps	.045"	110	240	115
.052"		125	286	124	250
1/16"		134	293	127	263

Typical Welding Parameters on reverse side of the sheet.

Applications

- Rail Road Car
- Shipbuilding
- General Fabrication
- Barges
- Light Equipment
- Civil Construction

Welding Process

FCAW

Classifications/Approvals

- AWS A5.20; E71T-1M-D/T-9M-D
- AWS A5.20; E71T-1C/T-9C
- ASME SFA 5.20
- A.B.S.
- Certified by C.W.B.- CSA W48
- Seismic Certified

Filler Metal Type

Mild Steel

Recommended Shielding Gas

75% Ar – 25% CO₂

www.dualshieldx.com

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TYPICAL WELDING PARAMETERS

Gas: 75/25 0.045"			Gas: 75/25 0.052"			Gas: 75/25 1/16"		
WFS	VOLT	AMP	WFS	VOLT	AMP	WFS	VOLT	AMP
150	19.0	110	125	20.0	125	98	20.0	134
180	19.8	123	165	20.6	157	113	20.6	160
210	20.5	136	200	21.3	187	128	21.2	178
240	21.3	149	225	22.0	197	144	21.9	194
270	22.0	162	250	22.6	200	159	22.5	215
300	22.8	175	275	23.3	220	174	23.1	230
330	23.5	188	300	23.9	241	189	23.7	240
360	24.3	201	325	24.6	249	204	24.3	257
390	25.0	214	350	25.2	256	220	25.0	260
420	25.8	227	375	25.7	263	235	25.6	270
450	26.5	240	400	26.3	286	250	26.2	293
Out-of-position welding applications								

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