

# DUAL SHIELD 700X

MILD STEEL  
FLUX CORED WIRES

## Tech Data Sheet



### TYPICAL MECHANICAL PROPERTIES

Shielding Gas	AS WELDED	
	CO <sub>2</sub>	
Yield Strength, ksi (MPa)	71	490
Tensile Strength, ksi (MPa)	82	565
% Elongation (in 2", 51mm)	27	

### TYPICAL CHARPY V-NOTCH IMPACT PROPERTIES

Shielding Gas	CO <sub>2</sub>	
	FT.-LBS.	(J)
Testing Temperature		
0°F (-18°C)	26	35
-20°F (-29°C)	20	27

### TYPICAL UNDILUTED WELD METAL ANALYSIS (%)

Shielding Gas	CO <sub>2</sub>
Carbon	0.04
Manganese	1.1
Silicon	0.5
Phosphorus	0.016
Sulfur	0.009
Nickel	0.4

### TYPICAL WELDING RANGE

Wire Feed Speed	Low	High
1/16"	150	550
3/32"	90	325
Volts		
1/16"	24.5	33.0
3/32"	26.0	35.0
Amps		
1/16"	170	440
3/32"	250	590
Deposition (lbs/Hr)		
1/16"	19.4	
3/32"	24.4	

Typical Welding Parameters on reverse side of the sheet.

#### Applications

Earth-Moving Equipment  
Heavy Machinery  
Large Steel Components

#### Welding Process

FCAW

#### Classifications/Approvals

AWS A5.20; E70T-1C  
ASME SFA 5.20  
A.B.S.  
Certified by C.W.B.- CSA W48

[www.dualshieldx.com](http://www.dualshieldx.com)

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### TYPICAL WELDING PARAMETERS

WFS	Gas: CO <sub>2</sub> 1/16"		WFS	Gas: CO <sub>2</sub> 3/32"	
	VOLT	AMP		VOLT	AMP
150	24.5	170	90	26.0	250
190	25.4	197	114	26.9	284
230	26.2	224	137	27.8	318
270	27.1	251	161	28.7	352
310	27.9	278	184	29.6	386
350	28.8	305	208	30.5	420
390	29.6	332	231	31.4	454
430	30.5	359	255	32.3	488
470	31.3	386	278	33.2	522
510	32.2	413	302	34.1	556
550	33.0	440	325	35.0	590

Flat & horizontal welding applications

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