

DUAL SHIELD 710X

MILD STEEL
FLUX CORED WIRES

Tech Data Sheet



TYPICAL MECHANICAL PROPERTIES

Shielding Gas	AS WELDED		AS WELDED	
	CO ₂		75/25	
Yield Strength, ksi (MPa)	75	520	83	570
Tensile Strength, ksi (MPa)	87	625	93	640
% Elongation (in 2", 51mm)	28		27	

TYPICAL CHARPY V-NOTCH IMPACT PROPERTIES

Shielding Gas	CO ₂		75/25	
	FT.-LBS.	(J)	FT.-LBS.	(J)
Testing Temperature				
0°F (-18°C)	57	77	75	102
-20°F (-29°C)	49	66	50	68

TYPICAL UNDILUTED WELD METAL ANALYSIS (%)

Shielding Gas	CO ₂		75/25	
Carbon	0.03		0.03	
Manganese	1.4		1.5	
Silicon	0.5		0.6	
Phosphorus	0.007		0.005	
Sulfur	0.009		0.009	
Nickel	0.4		0.4	

TYPICAL WELDING RANGE - Vertical Up

Wire Feed Speed	Low		High	
.045"	160	400	150	450
.052"	160	250	150	450
1/16"	98	250	120	270
Volts				
.045"	21.0	27.5	19.0	26.5
.052"	21.0	26.5	20.0	26.5
1/16"	20.0	26.2	20.0	26.5
Amps				
.045"	115	240	110	240
.052"	124	250	150	265
1/16"	127	263	160	285
Deposition (lbs/Hr)				
.045"		7.9		8.6
.052"		8.0		8.8
1/16"		8.4		9.2

Industry

Rail Road Car
Shipbuilding
General Fabrication
Civil Construction
Light Equipment

Welding Process

FCAW

Classifications/Approvals

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

www.dualshieldx.com

* 75/25 = 75% Argon / 25% CO₂

Typical Welding Parameters on reverse side of the sheet.

GREAT THINGS HAPPEN WHEN YOU PUT US TO WORK.

801 Wilson Ave., Hanover, PA 17331 • 1.800.ESAB.123 • www.esabna.com



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TYPICAL WELDING PARAMETERS

Gas: CO ₂ 0.045"			Gas: CO ₂ 0.052"			Gas: CO ₂ 1/16"		
WFS	VOLT	AMP	WFS	VOLT	AMP	WFS	VOLT	AMP
160	21.0	115	160	21.0	124	98	20.0	127
184	21.6	128	169	21.6	137	113	20.6	141
208	22.3	140	178	22.1	149	128	21.2	154
232	22.9	153	187	22.7	162	144	21.9	168
256	23.6	165	196	23.2	174	159	22.5	181
280	24.2	178	205	23.8	187	174	23.1	195
304	24.9	190	214	24.3	200	189	23.7	209
328	25.5	203	223	24.9	212	204	24.3	222
352	26.2	215	232	25.4	225	220	25.0	236
376	26.8	228	241	26.0	237	235	25.6	249
400	27.5	240	250	26.5	250	250	26.2	263
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	150	20.0	150	120	20.0	160
180	19.8	123	180	20.6	162	135	20.6	173
210	20.5	136	210	21.3	173	150	21.3	185
240	21.3	149	240	21.9	185	165	21.9	198
270	22.0	162	270	22.6	196	180	22.6	210
300	22.8	175	300	23.2	208	195	23.2	223
330	23.5	188	330	23.9	219	210	23.9	235
360	24.3	201	360	24.5	231	225	24.5	248
390	25.0	214	390	25.2	242	240	25.2	260
420	25.8	227	420	25.8	254	255	25.8	273
450	26.5	240	450	26.5	265	270	26.5	285
Out-of-position welding applications								

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