

DUAL SHIELD II 712X

MILD STEEL
FLUX CORED WIRES

Tech Data Sheet



TYPICAL MECHANICAL PROPERTIES

	AS WELDED	
	75/25	
Shielding Gas	75/25	
Yield Strength, ksi (MPa)	78	540
Tensile Strength, ksi (MPa)	83	570
% Elongation (in 2", 51mm)	28	

TYPICAL CHARPY V-NOTCH IMPACT PROPERTIES

	75/25	
Testing Temperature	FT.-LBS.	(J)
0°F (-18°C)	129	175
-40°F (-40°C)	93	126

TYPICAL UNDILUTED WELD METAL ANALYSIS (%)

Shielding Gas	75/25
Carbon	0.05
Manganese	1.1
Silicon	0.3
Phosphorus	0.009
Sulfur	0.010

TYPICAL WELDING RANGE - Vertical up

Wire Feed Speed	Low	High
.045"	160	455
.052"	130	360
1/16"	100	250
Volts		
.045"	19.5	26.5
.052"	20.0	25.5
1/16"	23.0	25.5
Amps		
.045"	129	248
.052"	135	260
1/16"	141	321
Deposition (lbs/Hr)		
.045"		9.3
.052"		9.4
1/16"		9.6

Typical Welding Parameters on reverse side of the sheet.

Applications

Off-shore Oil Components
Shipbuilding
Heavy Equipment

Welding Process

FCAW

Classifications/Approvals

AWS A5.20; E71T-1MJ/T-12MJ
ASME SFA 5.20
A.B.S.
Certified by C.W.B. - CSA W48

www.dualshieldx.com

* 75/25 = 75% Argon / 25% CO2

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: 75/25 0.045"			Gas: 75/25 0.052"			Gas: 75/25 1/16"		
WFS	VOLT	AMP	WFS	VOLT	AMP	WFS	VOLT	AMP
160	19.5	129	130	20.0	135	100	23.0	141
190	20.2	141	153	20.6	148	115	23.3	159
219	20.9	153	176	21.1	160	130	23.5	177
249	21.6	165	199	21.7	173	145	23.8	195
278	22.3	177	222	22.2	185	160	24.0	213
308	23.0	189	245	22.8	198	175	24.3	231
337	23.7	200	268	23.3	210	190	24.5	249
367	24.4	212	291	23.9	223	205	24.8	267
396	25.1	224	314	24.4	235	220	25.0	285
426	25.8	236	337	25.0	248	235	25.3	303
455	26.5	248	360	25.5	260	250	25.5	321
Out-of-position welding applications								

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