



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

EAGLE ARC 719

Carbon Steel

Flux-Cored Wire

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION:

EAGLE ARC 719 is a NON-baked flux cored wire designed for single or multi pass welding having a smooth arc transfer, low spatter, flat to slightly convex bead contour, with a high deposition rate and easily removal slag. This all-position baked wire has excellent feeding and low fume generation using 100% CO₂ or mixed gas making it a good choice for mild steel and higher strengths steels.

TYPICAL FCAW WELDING PROCEDURES; DCEP OPTIMUM IN BOLD (FLAT)

| Wire Diameter | Wire Speed (ipm) | Amps | Volts | Electrical Stickout | CO ₂ (cfh) |
|---------------|----------------------|----------------------|-------------------|---------------------|-----------------------|
| 0.035 | 275- 580 -780 | 130- 200 -260 | 23- 27 -30 | 3/8-3/4" | 35-40 |
| 0.045 | 200- 450 -600 | 150- 250 -335 | 22- 29 -33 | 1/2-1" | 35-45 |
| 0.052 | 150- 400 -600 | 140- 275 -390 | 19- 28 -35 | 1/2-1" | 40-50 |
| 1/16" | 150- 330 -490 | 150- 330 -475 | 23- 30 -38 | 1/2-1" | 40-50 |
| 5/64" | 120- 250 -300 | 250- 385 -450 | 26- 29 -32 | 3/4-1 1/4" | 40-50 |
| 3/32" | 110- 185 -275 | 300- 425 -550 | 25- 29 -34 | 3/4-1 1/4" | 40-50 |

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL WELD METAL CHEMISTRY (%) AND WELD METAL PROPERTIES;

| | AWS Spec. | 719 | BASED ON 100% CO ₂ / MIX 75/25 IN BOLD | | |
|------------|------------|---------------------|--|----------------|---------------------------|
| Carbon | 0.12 max | 0.038/ 0.043 | AWS Spec | 719 | |
| Manganese | 1.75 max | 1.30/ 1.48 | Tensile Strength (psi) | 70-95,000 | 84,143 / 90,794 |
| Silicon | 0.90 max | 0.44/ 0.52 | Yield Strength (psi) | 58,000 min. | 73,310 / 80,786 |
| Phosphorus | 0.030 max. | 0.009/ 0.018 | Elongation in 2" | 22 % min. | 30.5% / 28.8 % |
| Sulfur | 0.030 max. | 0.006/ 0.005 | Charpy V-notch at -20°F | 20 ft·lbs min. | 35.3 / 57.3 ft·lbs |
| Copper | 0.35 max. | 0.01/ 0.01 | | | |
| Nickel | 0.50 max. | 0.01/ 0.01 | Chromium | 0.20 max. | 0.04/ 0.04 |
| Molybdenum | 0.30 max. | 0.02/ 0.02 | Vanadium | 0.08 max. | 0.01/ 0.01 |

Hydrogen test on Lot # of F71LF00001161 with 100 CO₂ was @ 3.8(ml/100gl) and 75% Ar + 25% CO₂ was @ 4.2

AVAILABLE SIZES: TCC EAGLE-ARC 719= Spools of .045, .052, 1/16"

SPECIFICATIONS; AWS A5.20

ASME SFA 5.20

AWS A5.36

ASME SFA 5.36

E71T-1C/1M-9C/9M

E71T-1C/1M -9C/9M

E71T1-C1[M21]A0[A2]-CS1-H8

E71T1-C1[M21]A0[A2]-CS1-H8

(Formerly classified as E71T-1/-9)



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