



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](http://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% CO<sub>2</sub> 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 <sub>2</sub> (cfh)
0.035	275-580-780	130-200-260	23-27-30	3/8-3/4"	35-40
0.045	200- <b>450</b> -600	150- <b>250</b> -335	22- <b>29</b> -33	1/2-1"	35-45
0.052	150- <b>400</b> -600	140- <b>275</b> -390	19- <b>28</b> -35	1/2-1"	40-50
1/16"	150- <b>330</b> -490	150- <b>330</b> -475	23- <b>30</b> -38	1/2-1"	40-50
5/64"	120- <b>250</b> -300	250- <b>385</b> -450	26- <b>29</b> -32	3/4-1 1/4"	40-50
3/32"	110- <b>185</b> -275	300- <b>425</b> -550	25- <b>29</b> -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 <sub>2</sub> /	MIX 75/25 IN BOLD	AWS Spec	719
Carbon	0.12 max	0.038/ <b>0.043</b>	Tensile Strength (psi)	70-95,000	84,143 /	<b>90,794</b>
Manganese	1.75 max	1.30/ <b>1.48</b>	Yield Strength (psi)	58,000 min.	73,310 /	<b>80,786</b>
Silicon	0.90 max	0.44/ <b>0.52</b>	Elongation in 2"	22 % min.	30.5% /	<b>28.8 %</b>
Phosphorus	0.030 max.	0.009/ <b>0.018</b>	Charpy V-notch at -20°F	20 ft-lbs min.	35.3 /	<b>57.3 ft-lbs</b>
Sulfur	0.030 max.	0.006/ <b>0.005</b>	Chromium	0.20 max.	0.04/ <b>0.04</b>	
Copper	0.35 max.	0.01/ <b>0.01</b>	Vanadium	0.08 max.	0.01/ <b>0.01</b>	
Nickel	0.50 max.	0.01/ <b>0.01</b>				
Molybdenum	0.30 max.	0.02/ <b>0.02</b>				

Hydrogen test on Lot # of F71LF00001161 with 100 CO<sub>2</sub> was @ 3.8(ml/100gl) and 75% Ar + 25% CO<sub>2</sub> 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)



**APPROVALS:** ABS, CWB

**EAST COAST**  
7010-G Reames Rd  
Charlotte, NC 28216  
Tel (888) 522-8296  
Fax (704)598-6673

**GULF COAST**  
4755 Alpine Drive #100A  
Stafford, TX 77477  
Tel (877) 711-9274  
Fax (281)313-6332

**WEST COAST**  
8535 Utica Ave  
Rancho Cucamonga, CA 91730  
Tel(800)830-9033  
Fax (909)291-4586

8-2019 DC

Warehouse Distribution Center – Dayton, Ohio

Head Office – Puyallup, Washington

Washington Alloy Company believes that all information and data given is correct. Use this information to assist in making your own evaluations or decisions and this information should not be mistaken as an expressed or implied warranty. U.S. ALLOY CO. assumes no liability for results or damages incurred from the use of any information contained herein, in whole or in part.