



Manufacturers of Custom Welding Lines for Resale
www.selectrode.com

SELECTRODE 1127

Nickel Copper
Joining Electrode

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.11 E NiCu-7
DIN 1736: EL NiCu30Mn

EN ISO 14172E Ni4060
NiCu30Mn3Ti

FEATURES & APPLICATIONS

- Excellent for repairs in chlorine environments
- Used extensively in salt water and marine applications
- Works well as both a joining and cladding electrode

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

| C | Mn | Fe | P | S | Si | Ni | Al | Ti | Cu |
|-----|-----|-----|-----|-----|-----|----|-----|-----|------|
| .14 | 3.9 | 2.3 | .02 | .01 | 1.4 | 69 | .70 | 1.0 | Bal. |

Flux Color: Grey

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength
Yield Strength
Elongation

Maximum Value Up to:

80,000 PSI (540 MPa)
56,000 PSI (380 MPa)
36%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+)

| Diameter (mm) | 3/32 (2.5) | 1/8(3.25) | 5/32 (4.0) |
|------------------|------------|-----------|------------|
| Minimum Amperage | 70 | 90 | 110 |
| Maximum Amperage | 90 | 120 | 160 |

Welding Techniques: Use only dry electrodes. Redrying of the electrodes 2h at 250°C. Use stringer beads on clean joints and exempt of grease, oil or different oxides. Weld with a very short arc and hold the electrode 10-20° inclined in direction of travel.

Welding Positions: Flat, Horizontal, Vertical up, Overhead

Deposition Rates:

| Diameter (mm) | Length (mm) | Weldmetal/ Electrode | Electrodes per lb (kg) of Weldmetal | Arc Time of Deposition min/lb (kg) | Amperage Settings | Recovery Rate |
|---------------|-------------|----------------------|-------------------------------------|------------------------------------|-------------------|---------------|
| 3/32 (2.5) | 12" (300) | .35 oz. (10g) | 27 (59) | 25 (54) | 75 | 100% |
| 1/8 (3.25) | 14" (350) | .77 oz. (22g) | 14 (31) | 18 (41) | 95 | 100% |
| 5/32(4.0) | 14" (350) | 1.21oz. (34g) | 10 (22) | 12 (27) | 110 | 100% |

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

| | 3/32 (2.5) | 1/8 (3.25) | 5/32 (4.0) |
|-----------------|------------|------------|------------|
| Length (mm) | 12" (300) | 14" (350) | 14" (350) |
| Electrodes / lb | 27 | 14 | 10 |
| Electrodes / kg | 59 | 31 | 22 |