Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 1140

High Nickel Cast Iron Non-Conductive Flux

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.15 E Ni-CI
ISO 1071: E Ni
DIN 8573: E Ni BG 11
NFA 81-342: E Ni BG 11

FEATURES & APPLICATIONS

Very soft machinable welds on all weldable cast irons. Especially suited for welding in deep recesses or close quarters due to the non-conductive flux coating.

Soft very machinable high nickel cast iron electrode featuring a totally non-conductive flux coating.
Flux coating does not side arc even after being heated.

- Unusually strong arc drive penetrates oil and grease easily.
- Excellent for vertical up welding.
- Can be ordered in a red/brown flux color as product Code 1840.
- Also available in TIG form as product code 6004.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Austenitic nickel with finely distributed graphite flakes.

C	Mn	Si	S	P	Cu	Fe	Al	Misc	Ni
1.88	2.46	<4.0	.030	--	1.77	>4	.93	1 Max	Bal

Flux Color: Black or Red/Brown (code 1840)

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	**Maximum Value Up to:**
Tensile Strength	55,000 psi (380 MPa)
Yield Strength	38,000 psi (270 MPa)
Elongation	5%
Hardness	Rockwell B 82-84 Brinell 155 Vickers 14

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	70	80	130
Maximum Amperage	90	120	160

Welding Techniques: Maintain a close arc gap and move rapidly in the direction of travel. Slag can be welded over without removal.

Welding Positions: Flat, Vertical up, Vertical down, Horizontal, Overhead

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings
3/32 (2.5)	12" (300)	.64 oz (18g)	22 (48)	44 (97)	80
1/8 (3.25)	14"(350)	.77 oz (21g)	21 (47)	21 (46)	110
5/32 (4.0)	14" (350)	1.07 oz (31g)	15 (32)	20 (45)	135

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	12" (300)	14" (350)	14" (350)
Electrodes / lb	22	13	9
Electrodes / kg	48	29	20