



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

SELECTRODE 1146

Non-Machinable Cast Iron
Non-Conductive Flux

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.15 Est
DIN 8573: E Fe-1

ISO 1071: E Fe

FEATURES & APPLICATIONS

For non-machinable welds on machine bases, furnace grates, exhaust manifolds, etc.

Nickel free cast iron problem solver, seals in porosity generating contaminants prior to finish welding with nickels.

- Easily clads heat oxidized and oil impregnated castings
- Perfect color match to cast iron
- Non-conductive flux coating

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Black

C	Mn	Si	S	P	Fe
.12	.58	.02	.03	.03	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength
Yield Strength
Elongation
Hardness

Maximum Value Up to:

62,000 PSI (440 MPa)
50,000 PSI (360 MPa)
20%
Brinell 380, Rockwell C39

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+), AC

Diameter (mm)	3/32 (2.5)	1/8(3.25)	5/32 (4.0)
Minimum Amperage	45	70	95
Maximum Amperage	85	125	150

Welding Techniques: Use stringer or moderate weave technique. When cladding, cover the entire base surface prior to finish welding.

Welding Positions: Flat, vertical up, horizontal, vertical down, overhead

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Setting	Recovery Rate
3/32 (2.5)	14”(350)	.30 oz (8g)	53 (117)	36 (79)	70	100%
1/8 (3.25)	14”(350)	.62 oz (17g)	26 (57)	25 (55)	100	100%
5/32 (4.0)	14”(350)	1 oz (28g)	16 (35)	20 (44)	135	100%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	14” (350)	14” (350)	14” (350)
Electrodes / lb	26	14	10
Electrodes / kg	57	31	22