



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

SELECTRODE 1164

Ultra High Speed "Jet" Mild
Steel

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.1 E 7024
DIN 1913: E5122 RR 11 160
NFA 81-309: E512/2 RR 160 32

EN 499: E 380 RR 53
ISO 2560: E512 RR 160 32
BS 639: E5122 RR 160 32

FEATURES & APPLICATIONS

High speed horizontal fillet and lap welds on mild and some alloy steels. Excellent on earth moving and construction equipment, truck bodies, ships, barges, etc.

Ultra high speed "Jet" type mild steel joining electrode

- Fastest mild steel joining electrode available.
- Coating contains almost 60% iron powder.
- Self cleaning slag and virtually no spatter.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Olive brown

C	Mn	Ni	S	Cr	Si	Mo	P	V	Fe
.06	.91	.30	.02	.20	.26	.30	.014	.08	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength
Yield Strength
Elongation
Impact Energy

Maximum Value Up to:

86,000 psi (620 MPa)
77,000 psi (550 MPa)
27 %
35 J (25 ft. lbs.): -20 °F (-29°C)

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	140	180	250
Maximum Amperage	180	240	290

Welding Techniques: Drag technique should be used on horizontal and flat fillets. Tilt electrodes 5 to 10° in direction of travel and 40 to 50° from base plate in horizontal fillet.

Welding Positions: Flat, Horizontal

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
1/8 (3.25)	14" (350)	1.21oz (33g)	13 (29)	14 (31)	160	140%
5/32 (4.0)	14" (350)	1.56oz (44g)	10 (22)	11 (24)	210	140%
3/16 (5.0)	18" (450)	3.4oz (91g)	5 (11)	8 (18)	270	140%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (350)	14" (350)	18" (450)
Electrodes / lb	9	6	3
Electrodes / kg	20	13	7