



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

SELECTRODE 1165 High Speed Mild Steel

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.1-91 E 7014
DIN 1913: E 43 22RR C 6
ISO 2560 E43.2R 12

FEATURES & APPLICATIONS

For high speed filleting on general purpose carbon steel plate.

A high deposition mild steel electrode for all positions

- Weld 25% faster than other mild steel electrodes. Iron powder coating allows all position welding. Deposits are smooth and very uniform.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Tan

| P | C | Mn | Cr | Mo | Si | V | S | Ni | Fe |
|------|-----|-----|-----|-----|-----|-----|------|-----|------|
| .012 | .07 | .45 | .20 | .30 | .35 | .08 | .013 | .30 | Bal. |

TYPICAL MECHANICAL PROPERTIES

| Undiluted Weld Metal | Maximum Value Up to: |
|-----------------------------|-----------------------------|
| Tensile Strength | 87,000 PSI (630 MPa) |
| Yield Strength | 79,000 PSI (570 MPa) |
| Elongation | 26% |
| Impact Energy | 60J: 32°F (0°C) |

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+), Straight (-) or AC

| Diameter (mm) | 3/32 (2.5) | 1/8 (3.25) | 5/32 (4.0) |
|------------------|------------|------------|------------|
| Minimum Amperage | 70 | 110 | 140 |
| Maximum Amperage | 90 | 140 | 190 |

Welding Techniques: Hold a short arc length and travel as quickly as feasible. Use either a stringer or a weave technique.

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 | Recovery Rate |
|---------------|-------------|-------------------------|---|--|----------------------|------------------|
| 3/32 (2.5) | 14" (350) | .45oz (12g) | 36 (78) | 30 (66) | 80 | 115% |
| 1/8 (3.25) | 14" (350) | .93oz (25g) | 17 (38) | 20 (44) | 125 | 115% |
| 5/32 (4.0) | 14" (350) | 1.2oz (34g) | 13 (29) | 17 (37) | 165 | 115% |

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 | 21 | 13 | 9 |
| Electrodes / kg | 46 | 29 | 20 |