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1180

DESCRIPTION: 1180 is an outstanding welding electrode for welding higher strength piping, castings and forgings. The coating is specially formulated to resist moisture pick-up under conditions of high heat and humidity. The electrode offers resistance to moisture reabsorption which helps prevent hydrogen cracking and aids in elimination of starting porosity. Definitely a preferred electrode with high operator appeal.

APPLICATIONS:

1180 is used in welding chrome-moly pipes and boiler work.

FEATURES:

- Excellent arc characteristics
- Low spatter level
- Quick and easy slag removal
- Low moisture reabsorption
- Low smoke level
- Low hydrogen, less than 4 ml/100 g

BENEFITS:

- Stable, easy to control arc
- Improves weld bead appearance, higher deposition
- Reduces clean-up time
- Prevents starting porosity
- Welder safety and comfort
- Resistant to hydrogen-induced cracking

TYPICAL WELD METAL PROPERTIES*(Chem Pad):

Weld Metal Analysis		AWS Spec
Carbon (C)	0.10	0.05 to 0.12
Manganese (Mn)	0.69	0.90 max
Phosphorus (P)	0.01	0.03 max
Sulphur (S)	0.01	0.03 max
Silicon (Si)	0.50	0.80 max
Chromium (Cr)	2.35	2.00 to 2.50
Molybedenum (Mo)	1.06	0.90 to 1.20

TYPICAL MECHANICAL PROPERTIES*(SR):

	Stress relieved 1 hour at 1275°F	AWS Spec
Tensile Strength	125,000 psi (865 MPa)	90,000 min
Yield Strength	111,000 psi (765 MPa)	77,000 psi
Elongation % in 2"	18%	17%

TYPICAL CHARPY V-NOTCH IMPACT VALUES*(AW):

Not required

DIFFUSIBLE HYDROGEN: 3.4 ml/100 gr

CONFORMANCES AND APPROVALS:

- AWS A5.5, E9018-B3 H4R, ASME SFA 5.5, E9018-B3 H4R
- ABS



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RECOMMENDED WELDING PROCEDURES:

- GENERAL:** Electrode positive, work negative (DCEP) or AC
- ARC LENGTH:** Very short arc
- FLAT:** Angle electrode 10-15° from 90°
- VERTICAL-UP:** Use weaving techniques
- VERTICAL-DOWN:** Not recommended
- OVERHEAD:** Use slight weaving motion within the puddle
- STORAGE:** After opening, store in holding oven (250°F to 400°F) until used.
- RECONDITIONING:** If exposed to atmosphere for extended periods, reconditioned for one (1) hour at 600°F.

RECOMMENDED OPERATING PARAMETERS:

Diameter		Type of Power	Minimum Amps	Optimum* Amps	Maximum Amps
Inches	mm				
3/32	2.4	DCEP or AC	70	100	110
1/8	3.2	DCEP or AC	90	135	160
5/32	4.0	DCEP or AC	130	170	220
3/16	4.8	DCEP or AC	200	250	300

*For out of position welding, reduce amperages shown by 15%.

TYPICAL DEPOSITION RATES (at Optimum):

Diameter		Type of Power	Amperage	Deposition Rate Lbs/Hr.
Inches	mm			
3/32	2.4	DCEP	100	2.38
1/8	3.2	DCEP	135	2.92
5/32	4.0	DCEP	170	4.08
3/16	4.8	DCEP	250	5.62

AVAILABLE DIAMETERS AND PACKAGES:

Diameter		Length	
Inches	mm	Inches	mm
3/32	2.4	14"	355
1/8	3.2	14"	355
5/32	4.0	14"	355
3/16	4.8	14"	355