



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

SELECTRODE 1193

Pure Aluminum Flux Coated
Arc/Torch Alloy

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.3 E 1100
DIN: 1732: EL-Al

EN 573-3: E Al

FEATURES & APPLICATIONS

For arc welding aluminums alloyed with copper, silicon, and magnesium. Also excellent for joining dissimilar grades of aluminum.

Pure aluminum arc welding electrode with exclusive self lifting slag. Other aluminum grades such as 12%Si, 5%Si and Al Mn, etc. are also available.

- Unique self lifting slag.
- The only aluminum electrode manufactured in a "Low Temperature" 5/64 (2.0mm) x 10" (250mm) size.
- Pure white long shelf life extruded flux coating outlasts conventional products in moisture resistance.
- Can be manufactured in a variety of custom colors.
- Available in hermetically sealed PURE ALUMINUM pull ring cans or vacuum packed foil bags for extended shelf life.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: White or Custom Colors

Si	Cu	Fe	Mg	Mn	Zn	Be	Al
.091	.15	.8	0	.05	.1	.0008	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	34,000 psi (250 N/MPa)
Yield Strength	20,000 psi (150 N/MPa)
Elongation	5%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+)

Diameter (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	20	50	70	110
Maximum Amperage	60	80	120	150

Welding Techniques: Start by using the upper portion of the amperage range. Feed the electrode quickly and move fast maintaining a very close arc gap.

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
5/64 (2.0)	10" (250)	.08oz (2.6g)	184 (404)	176 (337)	40	90%
3/32 (2.5)	14" (350)	.14oz (4.3g)	114 (251)	110 (242)	70	90%
1/8 (3.25)	14" (350)	.23oz (6.5g)	70 (153)	62 (136)	110	90%
5/32 (4.0)	14" (350)	.33oz (9.6g)	48 (107)	47 (103)	135	90%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	10" (250)	14" (350)	14" (350)	14" (350)
Electrodes / lb	80	49	33	23
Electrodes / kg	176	108	73	51