Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 1120

E 320-16 Stainless

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 320-16
BS 2926 – 20.34.2.CUNB.B

FEATURES & APPLICATIONS

This electrode gives a fully austenitic, niobium stabilized weld metal with molybdenum and copper and a high resistance to corrosion in sulfuric acid, other mineral acids, organic acids and their mixes

High alloy super corrosion resistant austenitic alloy for joining “Alloy 20” stainless
• Controlled formula is resistant to attack by mineral and organic acid
• High strength combined with excellent corrosion resistance
• Excellent overall welding characteristics

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: In the as-welded condition deposits are fully austenitic
Flux Color: Grey/tan

Mo	Ni	C	Si	P	Mn	S	Cr	Cu	Fe
2.5	34	.02	.2	.01	2	.005	20	3.5	BAL

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	**Maximum Value Up to:**
Tensile Strength	92,000 PSI (675 MPa)
Yield Strength	75,000 PSI (525 MPa)
Elongation	Up to 28%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: AC/DC (+)

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32(4.0)
Minimum Amperage	50	70	90
Maximum Amperage	80	110	150

Welding Techniques: Maintain low amperage and do not allow interpass temperatures to exceed 374ºF (190ºC).

Welding Positions: Flat, Horizontal, Vertical up, 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)	12" (300)	.3oz (9g)	50 (109)	35 (76)	65	110%
1/8 (3.25)	14" (350)	.7oz (20g)	22 (49)	21 (46)	90	110%
5/32 (4.0)	14" (350)	1 oz (29g)	15 (33)	18 (40)	120	110%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	12" (300)	14" (350)	14" (350)
Electrodes / lb	24	12	8
Electrodes / kg	53	27	18