



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 1121 Cupronickel Electrode

INTERNATIONAL CLASSIFICATIONS

AWS A5.6 ECuNi

FEATURES & APPLICATIONS

1121 is a copper-nickel electrode for shielded metal arc welding of wrought or cast alloys of similar composition as well as 80/20 and 90/10 Cu/Ni alloys. It is also used for the clad side of copper-nickel clad steels. This filler metal is widely used in marine applications because of its good resistance to the corrosive effects of sea water.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Grey

Mn	Fe	Si	P	Cu	Ni	Ti	Pb
1.19	.5	.01	.005	67	31	.24	.003

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength

Yield Strength

Elongation

Maximum Value Up to:

61,600 PSI (425 N/mm²)

47,400 PSI (327 N/mm²)

38 %

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+)

Diameter (mm)	1/8 (3.2)	5/32 (4.0)	3/16" (5.0)
Minimum Amperage	65	95	130
Maximum Amperage	110	150	180

Welding Techniques: Use stringer beads on clean joints and exempt of grease or oil. Weld with a very short arc and hold the electrode 10-20° inclined in direction of travel.