



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 1133

Vertical Down 316L Stainless

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 316L-16

EN 1600: E 19 12 3 L R 31

DIN 8556: E 19.12.3 LR 16

ISO 3581: E 19.12.3 LR 31

NFA 81-343: EZ 19.12.3 LR 16

FEATURES & APPLICATIONS

Especially suited for vertical down and up welding of thin to medium gauge molybdenum bearing stainless steels.

Special vertical position stainless steel electrode

- Unique "Fast-Freeze" coating simplifies vertical down and up welding.
- Ideal for poor fit up joints in all positions.
- Controlled weld puddle allows for filling holes on stainless steels.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Austenite with 7-9% ferrite. Typical ferrite number is 6.

Flux Color: White

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe
.018	.9	.75	.01	.02	19	12	2.65	.1	bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	80,000 PSI (550 MPa)
Yield Strength	56,000 PSI (390 MPa)
Elongation	42%
Impact Energy	40J: -157°F (-105°C)
Hardness	Brinell 209, Rockwell B96

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

Diameter (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)
Minimum Amperage	35	60	90
Maximum Amperage	55	80	110

Welding Techniques: For vertical welding, set amperage at high end of the scale. Maintain a sharp angle with the electrode pointing upward. Whip the electrode quickly back and forth while moving up or down. Electrode may show a red color from the excess amperage which is normal.

Welding Positions: Flat, Horizontal, Vertical up, Vertical down, 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
5/64 (2.0)	12" (300)	.25oz (7g)	64 (141)	47 (103)	40	70%
3/32 (2.5)	12" (300)	.35oz (10g)	46 (101)	35 (76)	80	71%
1/8 (3.25)	12" (300)	.63 oz. (18g)	25 (56)	21 (46)	110	74%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)
Length (mm)	12" (300)	12" (300)	12" (300)
Electrodes / lb	42	30	18
Electrodes / kg	92	67	40