



Manufacturers of Custom Welding Lines for Resale  
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# SELECTRODE 1162

Double Coated Low Hydrogen

## INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.1 E 7016

EN 499: E 38 2 B 12 H10

DIN 1913: E 5153 B R 10

ISO 2560: E 515 B 26 (H)

NFA 81-309: E 515/3 B 26 BH

BS 639: E 5153 B 26 H

## FEATURES & APPLICATIONS

All position welding of fine grained unalloyed structural and construction grade steels with a carbon content of up to .4%.

New Technology - - Very unique "Double Coated" low hydrogen electrode excels at AC welding

- Unique "Double" flux coating separates those flux constituents which impair arc stability to the outside of the flux coating.
- The only "Low Hydrogen" electrode that can easily be used on low open circuit voltage AC farm type welders.
- The unusually stable arc makes this electrode ideally suited for root passes and positional welding.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Microstructure:** In the stress-relieved condition the microstructure consists of acicular ferrite with some tempered bainite.

**Flux Color:** White/Grey

C	Mn	Cr	Si	Mo	S	V	P	Ni	Fe
.08	1.12	.20	.60	.30	.011	.08	.010	.30	bal

## TYPICAL MECHANICAL PROPERTIES

<b>Undiluted Weld Metal</b>	<b>Maximum Value Up to:</b>
Tensile Strength	87,000 PSI (630 MPa)
Yield Strength	72,000 PSI (520 MPa)
Elongation	31%
Impact Energy	12°J: -20°C

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	60	90	140	200
Maximum Amperage	90	135	190	260

**Welding Techniques:** Clean areas to be joined. Initiate arc and use conventional "stringer weld" technique. Electrode can be dragged.

**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)	14" (350)	.42oz (12g)	38 (83)	38 (84)	75	118%
1/8 (3.2)	14" (350)	.59oz (17g)	27 (60)	21 (47)	115	118%
5/32 (4.0)	18" (450)	1.4oz (39g)	12 (26)	18 (39)	165	118%
3/16 (5.0)	18" (450)	2.3oz (64g)	7 (16)	13 (28)	230	118%

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (350)	14" (350)	18" (450)	18" (450)
Electrodes / lb	21	12	6	5
Electrodes / kg	46	26	14	10