



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

# SELECTRODE 1164

Ultra High Speed "Jet" Mild  
Steel

## INTERNATIONAL CLASSIFICATIONS

**AWS/ASME A 5.1 E 7024**

**EN 499: E 380 RR 53**

**DIN 1913: E5122 RR 11 160**

**ISO 2560: E512 RR 160 32**

**NFA 81-309: E512/2 RR 160 32**

**BS 639: E5122 RR 160 32**

## FEATURES & APPLICATIONS

High speed horizontal fillet and lap welds on mild and some alloy steels. Excellent on earth moving and construction equipment, truck bodies, ships, barges, etc.

Ultra high speed "Jet" type mild steel joining electrode

- Fastest mild steel joining electrode available.
- Coating contains almost 60% iron powder.
- Self cleaning slag and virtually no spatter.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Flux Color:** Olive brown

C	Mn	Ni	S	Cr	Si	Mo	P	V	Fe
.06	.91	.30	.02	.20	.26	.30	.014	.08	Bal.

## TYPICAL MECHANICAL PROPERTIES

**Undiluted Weld Metal**

**Maximum Value Up to:**

Tensile Strength	86,000 psi (620 MPa)
Yield Strength	77,000 psi (550 MPa)
Elongation	27 %
Impact Energy	35 J (25 ft. lbs.): -20 °F (-29°C)

## WELDING CURRENT & INSTRUCTIONS

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

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	140	180	250
Maximum Amperage	180	240	290

**Welding Techniques:** Drag technique should be used on horizontal and flat fillets. Tilt electrodes 5 to 10° in direction of travel and 40 to 50° from base plate in horizontal fillet.

**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
1/8 (3.25)	14" (350)	1.21oz (33g)	13 (29)	14 (31)	160	140%
5/32 (4.0)	14" (350)	1.56oz (44g)	10 (22)	11 (24)	210	140%
3/16 (5.0)	18" (450)	3.4oz (91g)	5 (11)	8 (18)	270	140%

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (350)	14" (350)	18" (450)
Electrodes / lb	9	6	3
Electrodes / kg	20	13	7