



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

# SELECTRODE 1165 High Speed Mild Steel

## INTERNATIONAL CLASSIFICATIONS

**AWS/ASME A 5.1-91 E 7014**  
**DIN 1913: E 43 22RR C 6**  
**ISO 2560 E43.2R 12**

## FEATURES & APPLICATIONS

For high speed filleting on general purpose carbon steel plate.

A high deposition mild steel electrode for all positions

- Weld 25% faster than other mild steel electrodes. Iron powder coating allows all position welding. Deposits are smooth and very uniform.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Flux Color:** Tan

P	C	Mn	Cr	Mo	Si	V	S	Ni	Fe
.012	.07	.45	.20	.30	.35	.08	.013	.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	79,000 PSI (570 MPa)

Elongation 26%  
 Impact Energy 60J: 32°F (0°C)

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Reverse (+), Straight (-) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	70	110	140
Maximum Amperage	90	140	190

**Welding Techniques:** Hold a short arc length and travel as quickly as feasible. Use either a stringer or a weave technique.

**Welding Positions:** Flat, Vertical up, Vertical down, Horizontal, 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)	.45oz (12g)	36 (78)	30 (66)	80	115%
1/8 (3.25)	14" (350)	.93oz (25g)	17 (38)	20 (44)	125	115%

5/32 (4.0)	14" (350)	1.2oz (34g)	13 (29)	17 (37)	165	115%
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**APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS**

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	14" (350)	14" (350)	14" (350)
Electrodes / lb	21	13	9
Electrodes / kg	46	29	20