



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

SELECTRODE 1166

Deep Penetrating for Dirty
Steels

INTERNATIONAL CLASSIFICATIONS

**NONE APPLICABLE TO THIS
PROPRIETARY PRODUCT**

FEATURES & APPLICATIONS

Ideally suited for difficult maintenance repairs. Easily welds steels that have been galvanized, painted, rusted, or otherwise contaminated in service. Misaligned parts or difficult to access areas are also easily remedied with this electrode.

Adverse conditions mild steel electrode. Excels on rusty, greasy, poor fitting joints in all positions.

- Can weld through 1/2 inch (12mm) of surface contamination without porosity.
- Can bridge gaps as wide as 3/8 inch (9mm).
- Electrode can be bent without flux chipping.
- Slag can be welded over without removal.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Dark Brown

C	Mo	Mn	Cr	Si	Ni	V	Fe
.09	.30	.59	.20	1.00	.30	.06	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	88,000psi (630 MPa)
Yield Strength	80,000psi (570 MPa)
Elongation	28%
Impact Energy	70J: -4°F (-20°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)	3/16 (5.0)
Minimum Amperage	25	35	50	75
Maximum Amperage	75	125	160	200

Welding Techniques: Weld with a short-medium arc length at low amperage. When surface preparation is impractical, use a medium-long arc and favor high amperages. Multi-pass welds can be made without intermittent slag removal. Use any welding technique from stringer bead to wide weave.

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
3/32 (2.5)	14" (350)	.27oz (7g)	45 (100)	37 (81)	50
1/8 (3.25)	14" (350)	.56oz (15g)	25 (56)	25 (56)	80
5/32 (4.0)	14" (350)	.9oz (25g)	17 (38)	20 (45)	105
3/16 (5.0)	14" (350)	1.35oz (38g)	12 (26)	15 (34)	140

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)	14" (350)	14" (350)
Electrodes / lb	31	18	11	8
Electrodes / kg	68	40	24	18