



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

SELECTRODE
1168
Red Mild Steel

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.1 E 6013
DIN 1913: E 5122 R C 3
NFA 81-309: E 512/2 R 12

EN 499: E 420 RC 11
ISO 2560 E 51.2RR22
BS 619: E 5122 R 12

FEATURES & APPLICATIONS

Versatile all around repair and fabrication of clean, well fitting common mild steel components. Fast freeze slag characteristics ensures fully positional operability.

Universal all position mild steel electrode available in a variety of colors

- Only mild steel electrode offering the convenience of flat , vertical up and down, and overhead without changing amperage setting.
- Four (4) colors kept in stock at all times Tan (1160), Blue (1159), Gold (1155) and Red (1168).
- Electrode can be bent without flux breakage.
- Contact (drag) type transfer allows the electrode to weld by itself.
- Also available as a torch fusion alloy as item #2161, a TIG alloy as item #6006, a solid MIG alloy as item #7070 and a flux cored MIG alloy as item #7160 and a gasless flux cored MIG alloy as item #7166.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Tan, Blue, Gold or Red or custom colors on request

C	Mn	V	Si	Mo	S	Ni	P	Cr	Fe
.08	.5	.08	.2	.30	.01	.30	.02	.20	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	83,000 psi (600 MPa)
Yield Strength	75,000 psi (540 MPa)
Elongation	25%
Impact Energy	90J: -4°F (-20°C)

WELDING CURRENT & INSTRUCTIONS

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

Diameter (mm)	1/16 (1.6)*	5/64 (2.0)*	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	20	30	50	70	115	150
Maximum Amperage	40	50	70	110	140	200

Welding Techniques: Hold a short to medium arc length, lean electrode 45° towards the direction of travel. Use either the stringer or 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
1/16 (1.6)*	12" (300)	.11oz (3g)	145 (320)	57 (125)	30
5/64 (2.0)*	12" (300)	.14oz (4g)	114 (251)	47 (103)	40
3/32 (2.5)	14" (350)	.30oz (8g)	53(117)	36 (79)	60
1/8 (3.2)	14" (350)	.62oz (17g)	26 (57)	25 (55)	90

5/32 (4.0)	14" (350)	1oz (28g)	16 (35)	20 (44)	125
3/16 (5.0)*	14" (350)	1.5oz (42g)	11 (23)	14 (31)	175

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/16 (1.6)*	5/64 (2.0)*	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)*
Length (mm)	12" (300)	12" (300)	14" (350)	14" (350)	18" (450)	18" (450)
Electrodes / lb	60	42	25	15	10	7
Electrodes / kg	132	92	55	33	22	15

*Only stocked in certain colors