



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

SELECTRODE 1169

All Position Low Hydrogen

INTERNATIONAL CLASSIFICATIONS

**NONE APPLICABLE TO THIS
PROPRIETARY PRODUCT**

FEATURES & APPLICATIONS

For joining and repairing boiler plate, pipe steels, shipbuilding steels and cast steels. Excellent for weathering steels, such as "Corten".

Extra low hydrogen – Moisture resistant steel electrode for unalloyed construction steel.

- Fast Deposition Rate
- Extremely smooth - spatter and turbulence free arc transfer.
- Unusually good AC welding characteristics.
- Easy re-strike.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

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

Flux Color: Red

| C | Mn | Si | S | P | Mo | Fe |
|-----|-----|-----|------|------|-----|------|
| .04 | .90 | .60 | .013 | .018 | .40 | Bal. |

| | |
|-----------------------------|-----------------------------|
| Undiluted Weld Metal | Maximum Value Up to: |
| Tensile Strength | 84,000 psi (610 MPa) |
| Yield Strength | 69,000 psi (500 MPa) |
| Elongation | 32% |

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

| Diameter (mm) | 1/16 (1.6) | 3/32 (2.5) | 1/8 (3.25) | 5/32 (4.0) | 3/16 (5.0) |
|------------------|------------|------------|------------|------------|------------|
| Minimum Amperage | 30 | 65 | 100 | 140 | 190 |
| Maximum Amperage | 45 | 100 | 140 | 190 | 250 |

Welding Techniques: Remove all surface contaminants. Maintain a short arc gap and use a stringer or slight weave technique. Chip slag thoroughly between passes.

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) | .13oz (49g) | 120 (264) | 59 (129) | 35 |
| 3/32 (2.5) | 14" (350) | .42oz (12g) | 38 (83) | 38 (84) | 80 |
| 1/8 (3.2) | 14" (350) | .59oz (17g) | 27 (60) | 21 (47) | 115 |
| 5/32 (4.0) | 14" (350) | 1.1oz (30g) | 15 (32) | 18 (39) | 175 |
| 3/16 (5.0) | 14" (350) | 1.8oz (50g) | 9 (20) | 13 (28) | 220 |

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

| | | | | | |
|-----------------|------------|------------|------------|------------|------------|
| Diameter (mm) | 1/16 (1.6) | 3/32 (2.5) | 1/8 (3.25) | 5/32 (4.0) | 3/16 (5.0) |
| Length (mm) | 12" (300) | 14" (350) | 14" (350) | 14" (350) | 14" (350) |
| Electrodes / lb | 54 | 21 | 12 | 8 | 6 |
| Electrodes / kg | 119 | 46 | 26 | 18 | 13 |