



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

SELECTRODE 1170

All Position / Deep Penetration
Mild Steel

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.1 E 6010
ISO 2560A E 42 2 C 25

DIN 499: E 42 2 C 25

FEATURES & APPLICATIONS

Ideally suited for difficult maintenance repairs. Easily welds steels that have been galvanized, painted, rusted, or otherwise contaminated in service. Easy to use out of position.

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

- Can bridge gaps as wide as 3/8 inch (9 mm).
- Slag can be welded over without removal
- Excellent for out of position work.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: White /Grey

C	Cr	Mn	Mo	Si	Ni	V	Fe
.20	.18	1.20	.25	.95	.25	.06	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Maximum Value Up to:

Tensile Strength	80,000 PSI (570 MPa)
Yield Strength	72,000 PSI (510 MPa)
Elongation	28%
Impact Energy	70J: -4°F (-20°C)

WELDING CURRENT & INSTRUCTIONS

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

Recommended Amperage Settings:

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
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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	27	18