



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

SELECTRODE

1171

Purple/Violet High Tensile Mild
Steel

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.5 E 9013 G
DIN NONE

FEATURES & APPLICATIONS

For joining common steels where extra strength is required in the weld. Exceptional where vertical welds have to be made.

Totally unique "High Tensile Mild Steel" electrode that excels at vertical welding

- Easy to use in all positions.
- Extra high tensile strength 97,000 psi (705 MPa).
- Special violet colored flux establishes immediate recognition.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Violet

C	Ni	Mn	Mo	Si	S	P	Cr	Fe
.07	.60	.60	.08	.40	.01	.02	.27	bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal
Tensile Strength

Maximum Value Up to:
97,000 PSI (705 MPa)

Yield Strength 78,500 PSI (565 MPa)
 Elongation 17%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	60	70	120
Maximum Amperage	80	110	150

Welding Techniques: Hold a very short arc. In the vertical position, electrode can actually be dragged.

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)	.30oz (8g)	53 (117)	36 (79)	70
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)	135

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	29	16	10
Electrodes / kg	64	35	22