



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 1174 Crack Resistant Low Hydrogen

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.5 E 8018B2L H4R

FEATURES & APPLICATIONS

Welding of higher strength steel structures that require tensile strengths greater than 80,000 (psi). This electrode offers excellent welding characteristics and easy slag removal.

Commonly used for fabrication and maintenance of boilers and associated piping. Such steels as 1 ¼ Cr – ½ Mo and ½ Cr – ½ Mo,

- Phenomenal combination of physical properties
- Excellent arc characteristics and deposit appearance
- Extra low moisture content
- Quick and easy slag removal

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: In the as-welded condition, the micro-structure is ferritic with a component of acicular ferrite for optimum toughness.

Flux Color: Grey

C	Mn	Si	S	P	Cr	Mo	Fe
.03	.69	.31	.01	.01	1.40	.55	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	98,000 psi (675 MPa)
Yield Strength	84,000 psi (579 MPa)
Elongation	24%
Impact Energy	-20C 46 ft•lbs

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	65	100	140	190
Maximum Amperage	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	Recovery Rate
3/32 (2.5)	14" (350)	.42oz (12g)	38 (83)	38 (84)	80	50
1/8 (3.25)	14" (350)	.59oz (17g)	27 (60)	21 (47)	115	80
5/32 (4.0)	14" (350)	1.1oz (30g)	15 (32)	18 (39)	175	105
3/16 (5.0)	14" (350)	1.8oz (50g)	9 (20)	13 (28)	220	140

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

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