



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

SELECTRODE

1191

12% Silicon Flux Coated
 Arc/Torch Aluminum Alloy

INTERNATIONAL CLASSIFICATIONS

AWS/ASME 5.3 E 4047
 DIN 1732: EL-Al Si12

EN 573-3: E AlSi12

FEATURES & APPLICATIONS

For arc welding aluminums alloyed with copper, silicon, and magnesium.
 Also excellent for joining dissimilar grades of aluminum.

12% Silicon aluminum arc welding electrode with exclusive self lifting slag. Other aluminum grades such as Al 99, Al Mn, etc. are also available.

- Unique self lifting slag.
- Pure white long shelf life extruded flux coating outlasts conventional products in moisture resistance.
- Can be manufactured in a variety of custom colors.
- Available in hermetically sealed PURE ALUMINUM pull ring cans or vacuum packed foil bags for extended shelf life.
- Also available in TIG form as item code 6047, in MIG form as item code 7091 and as a bare torch brazing alloy as item code 2191.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: White or Custom Colors

Si	Cu	Fe	Mg	Mn	Zn	Ti	Be	Al
12.1	.001	.15	.01	.003	.001	.008	.0001	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	36,000 psi (250 MPa)
Yield Strength	20,000 psi (150 MPa)
Elongation	14%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+)

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	50	70	110
Maximum Amperage	80	120	150

Welding Techniques: Start by using the upper portion of the amperage range. Feed the electrode quickly and move fast maintaining a very close arc gap.

Welding Positions: Flat, Horizontal

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)	.14oz (4.3g)	114 (251)	110 (242)	70	90%
1/8 (3.25)	14” (350)	.23oz (6.5g)	70 (153)	62 (136)	110	90%
5/32 (4.0)	14” (350)	.33oz (9.6g)	48 (107)	47 (103)	135	90%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	14” (350)	14” (350)	14” (350)
Electrodes / lb	49	33	23
Electrodes / kg	108	73	51