



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

SELECTRODE
1194
**5% Silicon Flux Coated Arc/
 Torch Aluminum Alloy**

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.3 E 4043
DIN 1732: EL –Al Si5

EN 573-3: E AlSi5

FEATURES & APPLICATIONS

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

5% 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.
- The only aluminum electrode manufactured in a "Low Temperature" 5/64 (2.0mm) x 10" (250mm) size.
- 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 6009, in MIG form as item code 7090 and as a bare torch brazing alloy as item code 2190.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Light Green

Si	Cu	Fe	Mg	Mn	Zn	Ti	Be	Al
5.25	.01	.17	.002	.002	.001	.01	.0001	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	32,000 psi (230 MPa)
Yield Strength	20,000 psi (150 MPa)
Elongation	18%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+)

Diameter (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	20	50	70	110
Maximum Amperage	60	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
5/64 (2.0)	10" (250)	.08oz (2.6g)	184 (404)	176 (337)	40	90%
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

Diameter (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	10" (250)	14" (350)	14" (350)	14" (350)
Electrodes / lb	80	49	33	23
Electrodes / kg	176	108	73	51