



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

SELECTRODE
1195
**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: Blue or Custom Colors

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