



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

# SELECTRODE 1198

Manganese Aluminum Flux  
Coated Electrode

## INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.3 E 3003  
DIN: 1732: EL Si-Al Mn

## FEATURES & APPLICATIONS

For arc welding aluminums alloyed with manganese and magnesium. Also excellent for joining dissimilar grades of aluminum and for seawater applications.

Aluminum arc welding electrode with exclusive self lifting slag. Other aluminum grades such as 12%Si, 5%Si and E 1100, 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.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Flux Color:** White or Custom Colors

Si	Cu	Fe	Zn	Mn	Be	Zr	Ti	Al
0.14	.07	0.23	.002	1.3	.0001	.0004	.009	Bal.

## TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	34,000 psi (250 N/MPa)
Yield Strength	20,000 psi (150 N/MPa)
Elongation	10%

## 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

Diameter (mm)	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