



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

SELECTRODE 1127

Nickel Copper
Joining Electrode

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.11 E NiCu-7
DIN 1736: EL NiCu30Mn

EN ISO 14172E Ni4060
NiCu30Mn3Ti

FEATURES & APPLICATIONS

- Excellent for repairs in chlorine environments
- Used extensively in salt water and marine applications
- Works well as both a joining and cladding electrode

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Fe	P	S	Si	Ni	Al	Ti	Cu
.14	3.9	2.3	.02	.01	1.4	69	.70	1.0	Bal.

Flux Color: Grey

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength

Yield Strength

Elongation

Maximum Value Up to:

80,000 PSI (540 MPa)

56,000 PSI (380 MPa)

36%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+)

Diameter (mm)	3/32 (2.5)	1/8(3.25)	5/32 (4.0)
Minimum Amperage	70	90	110
Maximum Amperage	90	120	160

Welding Techniques: Use only dry electrodes. Redrying of the electrodes 2h at 250°C. Use stringer beads on clean joints and exempt of grease, oil or different oxides. Weld with a very short arc and hold the electrode 10-20° inclined in direction of travel.

Welding Positions: Flat, Horizontal, Vertical up, 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)	12" (300)	.35 oz. (10g)	27 (59)	25 (54)	75	100%
1/8 (3.25)	14" (350)	.77 oz. (22g)	14 (31)	18 (41)	95	100%
5/32(4.0)	14" (350)	1.21oz. (34g)	10 (22)	12 (27)	110	100%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	12" (300)	14" (350)	14" (350)
Electrodes / lb	27	14	10
Electrodes / kg	59	31	22