



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

# SELECTRODE 1161

7018 Moisture Resistant Low  
Hydrogen

## INTERNATIONAL CLASSIFICATIONS

**AWS/ASME A 5.1 E 7018-1**

**EN 499: E 42 4 B 12 H5**

**DIN 1913: E51 54B R 10**

**ISO 2560: E51 5B120 26H**

**NFA 81-309: E515/4 B 120 26 BH**

**BS 639: E 5154 B 120 26 (H)**

## FEATURES & APPLICATIONS

For joining and repairing boiler plate, pipe steels, shipbuilding steels and cast steels. Excellent for weathering steels, such as "Corten".

Extra low hydrogen – Moisture resistant steel electrode for unalloyed construction steels

- Only low hydrogen alloy made in 1/16 (1.6mm) size.
- Extremely smooth - spatter and turbulence free arc transfer.
- Coating is totally non-conductive.
- Unusually good AC welding characteristics.
- Easy re-strike.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Microstructure:** In the stress-relieved condition, the microstructure consists of acicular ferrite with some tempered bainite.

**Flux Color:** Tan/grey

C	Mn	Si	S	P	Mo	Fe
.04	.90	.60	.013	.018	.40	Bal.

**Undiluted Weld Metal**

Tensile Strength  
 Yield Strength  
 Elongation  
 Impact Energy

**Maximum Value Up to:**

84,000 psi (610 MPa)  
 69,000 psi (500 MPa)  
 32%  
 90J: -30°C

**WELDING CURRENT & INSTRUCTIONS****Recommended Current:** DC Reverse (+) or AC

Diameter (mm)	1/16 (1.6)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	30	65	100	140	190
Maximum Amperage	45	100	140	190	250

**Welding Techniques:** Remove all surface contaminants. Maintain a short arc gap and use a stringer or slight weave technique. Chip slag thoroughly between passes.

**Welding Positions:** Flat, Vertical up, Vertical down, Horizontal, Overhead

**Deposition Rates:**

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings
1/16 (1.6)	12" (300)	.13oz (49g)	120 (264)	59 (129)	35
3/32 (2.5)	14" (350)	.42oz (12g)	38 (83)	38 (84)	80
1/8 (3.2)	14" (350)	.59oz (17g)	27 (60)	21 (47)	115
5/32 (4.0)	14" (350)	1.1oz (30g)	15 (32)	18 (39)	175
3/16 (5.0)	14" (350)	1.8oz (50g)	9 (20)	13 (28)	220

**APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS**

Diameter (mm)	1/16 (1.6)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	12" (300)	14" (350)	14" (350)	14" (350)	14" (350)
Electrodes / lb	54	21	12	8	6
Electrodes / kg	119	46	26	18	13