



Manufacturers of Custom Welding Lines for Resale  
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# SELECTRODE 1167

High Deposition 316L Stainless  
Steel

## INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 316L-26

EN 1600: E 19.12.3LR 73

DIN 8556: E 19.12.3 LMPR 26 160

ISO 3581: E 19.12.3 LR 73

NFA 81-343: EZ 19.12.3 LR 160 23 X

## FEATURES & APPLICATIONS

For welding and cladding stabilized and unstabilized stainless steels to themselves and to carbon steels.

Fully synthetic 316 stainless high performance joining and cladding electrode

- A true non-overheating 316 stainless steel electrode.
- Very high speed weld deposition compares with MIG welding.
- Self releasing slag - eye appealing welds.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Microstructure:** Austenite with 7-9% ferrite. Typical ferrite number 6.

**Flux Color:** Grey

Mo	Ni	C	Si	P	Mn	S	Cr	Cu	Cb
2.8	12.6	.06	.90	.02	.91	.01	17.91	.11	.05

## TYPICAL MECHANICAL PROPERTIES

<b>Undiluted Weld Metal</b>	<b>Maximum Value Up to:</b>
Tensile Strength	107,000 PSI (750 MPa)
Yield Strength	75,000 PSI (520 MPa)
Elongation	36%
Impact Energy	40J: -157oF (-105oC),
Hardness	Brinell 190, Rockwell B92

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Reverse (+) or AC

Diameter (mm)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	50	65	90	145
Maximum Amperage	75	105	145	215

**Welding Techniques:** Weld with the electrode tilted slightly using a short arc or the drag technique. This high recovery electrode allows you to use smaller than normal electrode diameters.

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

**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
1/16 (1.6)	10" (250)	.35oz (10g)	46 (102)	36 (79)	65	170%
3/32 (2.5)	14" (350)	.7 oz. (20g)	23 (50)	25 (56)	85	170%
1/8 (3.25)	14"(350)	1.14oz (32g)	14 (30)	17 (38)	120	170%
5/32 (4.0)	14" (350)	1.78 oz (50g)	9 (20)	10 (23)	180	170%

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/16 (1.6)	5/64 (2.0)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	10" (250)	12" (300)	12" (300)	14" (350)	14" (350)
Electrodes / lb	67	42	28	13	9
Electrodes / kg	147	92	62	29	20