



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

**SELECTRODE**  
**1168**  
**Red Mild Steel**

**INTERNATIONAL CLASSIFICATIONS**

**AWS/ASME A 5.1 E 6013**  
**DIN 1913: E 5122 R C 3**  
**NFA 81-309: E 512/2 R 12**

**EN 499: E 420 RC 11**  
**ISO 2560 E 51.2RR22**  
**BS 619: E 5122 R 12**

**FEATURES & APPLICATIONS**

Versatile all around repair and fabrication of clean, well fitting common mild steel components. Fast freeze slag characteristics ensures fully positional operability.

Universal all position mild steel electrode available in a variety of colors

- Only mild steel electrode offering the convenience of flat , vertical up and down, and overhead without changing amperage setting.
- Four (4) colors kept in stock at all times Tan (1160), Blue (1159), Gold (1155) and Red (1168).
- Electrode can be bent without flux breakage.
- Contact (drag) type transfer allows the electrode to weld by itself.
- Also available as a torch fusion alloy as item #2161, a TIG alloy as item #6006, a solid MIG alloy as item #7070 and a flux cored MIG alloy as item #7160 and a gasless flux cored MIG alloy as item #7166.

**ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)**

**Flux Color:** Tan, Blue, Gold or Red or custom colors on request

C	Mn	V	Si	Mo	S	Ni	P	Cr	Fe
.08	.5	.08	.2	.30	.01	.30	.02	.20	Bal.

## TYPICAL MECHANICAL PROPERTIES

<b>Undiluted Weld Metal</b>	<b>Maximum Value Up to:</b>
Tensile Strength	83,000 psi (600 MPa)
Yield Strength	75,000 psi (540 MPa)
Elongation	25%
Impact Energy	90J: -4°F (-20°C)

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Straight (-), Reverse (+) or AC

Diameter (mm)	1/16 (1.6)*	5/64 (2.0)*	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	20	30	50	70	115	150
Maximum Amperage	40	50	70	110	140	200

**Welding Techniques:** Hold a short to medium arc length, lean electrode 45° towards the direction of travel. Use either the stringer or weave technique.

**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)	.11oz (3g)	145 (320)	57 (125)	30
5/64 (2.0)*	12" (300)	.14oz (4g)	114 (251)	47 (103)	40
3/32 (2.5)	14" (350)	.30oz (8g)	53(117)	36 (79)	60
1/8 (3.2)	14" (350)	.62oz (17g)	26 (57)	25 (55)	90

5/32 (4.0)	14" (350)	1oz (28g)	16 (35)	20 (44)	125
3/16 (5.0)*	14" (350)	1.5oz (42g)	11 (23)	14 (31)	175

### 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)	3/16 (5.0)*
Length (mm)	12" (300)	12" (300)	14" (350)	14" (350)	18" (450)	18" (450)
Electrodes / lb	60	42	25	15	10	7
Electrodes / kg	132	92	55	33	22	15

\*Only stocked in certain colors