



Manufacturers of Custom Welding Lines for Resale
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1185

High Deposition 309L Stainless
Steel

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 309L – 26

EN: E23 12 LR 32

ISO 3581: E23 12 LR 32

FEATURES & APPLICATIONS

Wherever maximum ductility is required when joining dissimilar steels to themselves or to stainless steels

Extra strong and tough stainless steel electrode for joining steels to stainless steels

- Highly recommended for joining hard to weld steels
- Moisture resistant coating provides sound porosity free deposits
- Slag is self removing
- Very high speed weld deposition compares to MIG welding

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Austenite with a ferrite number of 8

Flux Color: Grey

C	Mn	Si	Cr	Ni	Fe
.04	1.8	.6	23.3	12.5	bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	110,000 PSI (750 MPa)
Yield Strength	76,000 PSI (530 MPa)
Elongation	32%
Impact Energy	50J: 68°F (20°C)

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+) or AC

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

Welding Techniques: Material to be welded should be clean of all contaminates. Weld with 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
3/32 (2.5)	14" (350)	.7oz (20g)	18 (40)	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)	1.78oz (50g)	9 (20)	10 (23)	180	170%

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	16	13	9
Electrodes / kg	35	29	20