



Manufacturers of Custom Welding Lines for Resale
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7161

Mild Steel Flux Cored MIG
Wire

INTERNATIONAL CLASSIFICATIONS

AWS Specification: AWS A5.20

AWS Classification: E71T-11

FEATURES & APPLICATIONS

7161 is an all-position, self-shielding flux cored welding wire, which is intended for single and multiple pass welding of low-alloy and carbon steel where a minimum 70,000 psi tensile strength and good notch toughness is required. It is an excellent general purpose welding wire. This wire has very low fume, stable arc, good slag removal and excellent mechanical properties

Typical Applications:

- Buff and fillet welding of hulls and storage tanks.
- Structural steel
- Farm machinery
- Construction equipment
- General carbon steel fabrication

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Si	P	S	Al
.28	.032	.10	.007	.004	1.49

TYPICAL MECHANICAL PROPERTIES (AS WELDED)

Yield Strength: 91,000 PSI (627MPa)

Tensile Strength: 62,000 PSI (427MPa)

% Elongation: 22%

WELDING CURRENT & INSTRUCTIONS

Welding Current: DCEN (Direct Current Electrode Negative)

Welding Positions: All position

Recommended Welding Parameters:

Diameter	Amperage	Voltage	Wire Speed (ipm)	Stick Out
.035" (0.9mm)	55-120	17-20	75-160	1/2"
.045" (1.2mm)	115-200	15-18	105-195	1/2"
1/16" (1.6mm)	160-260	17-20	70-145	3/4"