Select EH12KS

Description:

Select EH12KS is a metal cored, carbon steel electrode for submerged arc welding. It is intended for single and multiple pass welding of carbon, and certain low alloy, steels in the flat and horizontal fillet positions. High levels of manganese and silicon allow improved performance over rust and mill scale. This electrode should be used for submerged arc welding only.

Classification:

- EC1 per AWS A5.17, SFA 5.17.

Characteristics:

Select EH12KS is designed to produce a weld deposit chemistry equivalent to that produced by solid wire, EH12K electrodes. The cored wire design results in higher deposition rates than solid, wire when run at the same current level.

Select EH12KS allows for better control of bead penetration than solid wire. The penetration pattern for a cored electrode is broader and slightly shallower, reducing the tendency for burn through on root passes or poorly fit up joints.

Applications:

Select EH12KS is ideal for those applications involving the welding of structural carbon steels such as A36, A285, A515, and A516. It may be used with neutral or active fluxes and may be substituted anywhere a solid wire, EH12K electrode is used.

Typical Electrode Chemistry

Wt%	C	Mn	Si	P	Si
	.10	1.65	.010	.010	.55

Recommended Welding Parameters:

	Amps	Volts	Wire Feed Speed (ipm)	ESO (in)
5/64”	250	26-27	90	¾”-1¼”
	350	29-30	160	
	500	32-33	290	
3/32”	275	28-29	80	1”-1¼”
	450	32-33	155	
	600	37-38	245	
1/8”	300	28-29	45	1”-1¼”
	550	32-33	105	
	750	37-38	180	
5/32”	425	31-32	45	1¼”-1½”
	700	37-38	105	
	900	31-42	180	

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