



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

SELECTRODE 1284

Nickel Manganese Aluminum
Bronze Electrode

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.6 E CuMnNiAl
DIN 1733: EL-CuMn14Al

FEATURES & APPLICATIONS

Joining and surfacing parts subject to service in marine environments and seawater.

Very high strength nickel manganese aluminum bronze electrode with excellent wear resistance.

- Universal electrode safely repairs all grades of aluminum bronzes.
- Resists corrosion, cavitation, erosion, and metal to metal wear.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Complex alpha matrix with kappa compound phases and some retained beta phase.

Flux Color: Grey

| Mn | Si | Ni | Fe | Pb | Al | Cu |
|------|----|-----|----|-----|-----|-----|
| 12.7 | .6 | 2.3 | 3 | .02 | 5.6 | Bal |

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength
Yield Strength
Elongation
Hardness

Maximum Value Up to:

96,000 PSI (650 MPa)
65,000 PSI (450 MPa)
20%
Brinell 155, Rockwell B87

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+)

| Diameter (mm) | 1/8 (3.25) | 5/32 (4.0) | 3/16 (5.0) |
|------------------|------------|------------|------------|
| Minimum Amperage | 90 | 105 | 135 |
| Maximum Amperage | 130 | 155 | 210 |

Welding Techniques: Preheat is not required. Maintain a short arc gap. Clean slag thoroughly between passes.

Welding Positions: Flat

Deposition Rates:

| Diameter (mm) | Length (mm) | Weldmetal / Electrode | Electrodes per lb (kg) of Weldmetal | Arc Time of Deposition min/lb (kg) | Amperage Settings |
|---------------|-------------|-----------------------|-------------------------------------|------------------------------------|-------------------|
| 1/8 (3.25) | 14" (350) | .8 oz. (22g) | 20 (45) | 25 (54) | 110 |
| 5/32 (4.0) | 14" (350) | 1.1 oz (32g) | 14 (31) | 16 (36) | 135 |
| 3/16 (5.0) | 14" (350) | 1.6 oz (45g) | 10 (22) | 13 (28) | 180 |

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

| Diameter (mm) | 1/8 (3.25) | 5/32 (4.0) | 3/16 (5.0) |
|-----------------|------------|------------|------------|
| Length (mm) | 14" (350) | 14" (350) | 14" (350) |
| Electrodes / lb | 13 | 9 | 6 |
| Electrodes / kg | 29 | 20 | 13 |