



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE
1123
Hastelloy C Electrode
High Recovery

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.11 E NiCrMo-5

DIN 8555: E 23-UM-250CKNTZ

FEATURES & APPLICATIONS

Ideally suited for applications involving both heat and corrosion, joining dissimilar nickel alloys or joining these alloys to the stainless steels. For fabrication and repairing chemical vats, retorts, valves and valve bodies, plating tanks, racks and supports, chemical pipelines, evaporators, digestors, hot-work forging dies, furnace racks, hoods and baffles, pumps, valves and controls.

The most outstanding, universal "one product" for all applications involving resistance to corrosion

- Deposits are rich in chromium, nickel and molybdenum.
- Offers the best resistance to oxidizing and reducing acids and alkalis even at elevated temperatures.
- Performs on AC as well as DC.
- Extremely tough weld metal that work hardens.
- Also Available in TIG form as product code 6023.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Grey

C	Mn	Si	S	P	Cr	Nb	Fe	Mo	Cu	W	Co	Ni
.05	1.0	.4	.005	.008	15.5	1.2	7.0	17.0	.05	3.2	2.5	bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	85,000 PSI (600 MPa)
Yield Strength	78,000 PSI (540 MPa)
Elongation	32 %
Hardness	220 Brinell, Rockwell C18
Work Hardness	450 Brinell, Rockwell C44

WELDING CURRENT & INSTRUCTIONS

Recommended Current: AC or DC reverse polarity

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	50	75	120
Maximum Amperage	90	165	180

Welding Techniques: Clean area to be welded, removing all contaminating materials and old weld metal. Prepare joint edges. No preheat is usually necessary, nor desirable. Apply using any technique suited to the application - stringer bead, moderate or wide weaving, etc. Allow to cool and remove slag.

Welding Positions: Flat, Horizontal

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)	.69 oz. (19.5g)	23 (50)	16 (36)	85	160%
1/8 (3.25)	14"(350)	1.14 oz (32g)	14 (30)	11 (25)	110	160%
5/32 (4.0)	14" (350)	1.78 oz (50g)	9 (20)	9 (19)	145	160%

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	13	8	5
Electrodes / kg	28	17	11