



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 1222

High Recovery Inconel
625 (112) Electrode

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.11 E NiCrMo-3
DIN 1736: EL NiCr20Mo9Nb

EN/ISO 14172: ENi6625 NiCr22Mo9Nb

FEATURES & APPLICATIONS

For joining and cladding most nickel alloys, stainless steels, and carbon steels. Excellent for oxidation and corrosion resistant applications.

Inconel 625 electrode that performs on AC current as well as DC current

- Rare version of this "Super Alloy" that works perfectly on small AC machines.
- Welds can withstand temperature extremes ranging from 1900°F to -140°F (1050°C to – 196°C).
- Welding characteristics and weld appearance are exceptional.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Blue-Grey

C	Mn	Si	S	P	Cr	Nb	Fe	Mo	Cu	Ni
.05	.8	.4	.005	.008	22	3.5	7	9	.05	bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Maximum Value Up to:

Tensile Strength	136,000 PSI (950 MPa)
Yield Strength	95,000 PSI (660 MPa)
Elongation	40%
Impact Energy	65J: -320°F (-196°C)
Hardness	Brinell 238, Rockwell C22
Work Hardness	Brinell 428, Rockwell C45

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	70	100	130
Maximum Amperage	95	135	175

Welding Techniques: Weld with lowest amperage feasible using a very short arc gap. Welds can be deposited using the stringer or 3X weave technique.

Welding Positions: Flat, Horizontal, Vertical Up, Overhead

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	7	5
Electrodes / kg	28	16	11