



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

SELECTRODE
1225
Cobalt Grade 25 Electrode

INTERNATIONAL CLASSIFICATIONS

DIN 8555: E20-UM-250-CKTZ

EN 14700: E CO 1

FEATURES & APPLICATIONS

Excellent for repair of turbine blades, valves, forging dies and tools

- Very smooth arc characteristics
- Easily controlled molten weldmetal
- Works equally well on both AC and DC current
- Available bare as code 1295

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Si	Mn	Cr	Ni	W	Fe	Co
.1	.9	1.1	20	10.3	15.2	2.1	Bal.

Flux Color: Grey

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Maximum Value Up to:

Hardness

Room Temperature 68°F (20°C) Rockwell C25

Elevated Temperature 1100°F (600°C) Rockwell C30

TDS 1225 – Revision 03/07/13

WELDING CURRENT & INSTRUCTIONS

Recommended Current: AC or DC Reverse (+)

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	65	80	100
Maximum Amperage	85	110	130

Welding Techniques: Preheat massive parts to 570°F (300°C). Minimize amperage during welding.

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)	.80 oz. (22g)	20 (44)	19 (42)	75	130%
1/8 (3.25)	14"(350)	1.2 oz (33g)	13 (29)	14 (31)	95	130%
5/32 (4.0)	14" (350)	1.56 oz (44g)	10 (22)	11 (24)	115	130%

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	18	11	7
Electrodes / kg	40	25	16