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

SELECTRODE 1231

60% Tungsten Carbide Tubular Torch Alloy

INTERNATIONAL CLASSIFICATIONS

Proprietary Formula – None Applicable

FEATURES & APPLICATIONS

Ideally suited for overlaying mining and earth moving equipment. Excellent for wire saws and other edges requiring cutting action combined with abrasion resistance.

A seemed tubular rod identical in construction to 1230 with the exception that it is not flux coated. This bare alloy is designed for use without flux using both oxyacetylene and TIG processes.

- Specially selected carbides for maximum cutting action.
- Extremely high percent of tungsten carbide.
- Primary carbides provide maximum cutting action, while secondary carbides dissolve to strengthen matrix.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Wc	Mn	Fe
60	1.0	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	**Maximum Value Up to:**
Carbide Hardness	VPN 1200

Matrix Hardness	RC 66-70
Coverage	Approx. 30 sq inches (1/16 thick)
Deposition Efficiency	Greater than 90%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: TIG DC (-), oxyacetylene – slightly carburizing flame adjustment

Welding Techniques: Preheat with oxy-acetylene torch until the starting area is a dull red color. Allow deposits to slow cool.