



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

SELECTRODE 1235

37% Tungsten Carbide
Tubular Electrode

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.

An economical version of 1230 manufactured with the exact same materials with a “Virgin” Tungsten Carbide content between 35 and 40% by weight.

- Specially selected carbides for maximum cutting action.
- Primary carbides provide maximum cutting action, while secondary carbides dissolve to strengthen matrix.
- The black dipped flux coating stabilizes the arc and allows for uniform transfer of the carbides
- Excellent for drilling applications that involve some impact.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Wc	Mn	Fe
35-40	1.0	bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Maximum Value Up to:

Carbide Hardness	VPN 1200
Matrix Hardness	RC 45
Coverage	Approx. 30 sq inches (1/16 thick)
Deposition Efficiency	Greater than 90%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC either polarity or AC

Recommended Amperage Settings

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	70	100	150
Maximum Amperage	120	170	210

Welding Techniques: Clean surface and remove old overlays and loosely adhering metal. Established the arc holding the electrode near perpendicular and move quickly in the direction of travel. Use the stringer bead technique only – do not weave. Pull electrode out of final crater – do not back-whip. Normally a second pass will not be required. Deposits made this way will provide trapped projecting carbides for maximum cutting action.