



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

SELECTRODE
1247
High Manganese
Stainless

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.4 E 307-16

EN 1600: E 18 8 Mn R 32

DIN 8556: E 18.8 Mn R 26

ISO 3581: E 18.8 Mn R 32

NFA 81-343: EZ 18.8 MnR 26

FEATURES & APPLICATIONS

For reclaiming and joining 14% manganese steels, as well as non-alloy and alloy structural and heat treatable steels.

Non-synthetic, non-magnetic, high manganese stainless for joining and buffer layers.

- "Non-magnetic" weld metal is not susceptible to cracking and possesses high deformation capacity.
- Joins armor steels to themselves as well as to mild, stainless and manganese steels.
- Offers a rare combination of toughness, crack resistance and impact resistance.
- Easy and complete slag removal.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Austenite with a ferrite content of 5FN.

Flux Color: Grey/Tan

C	Mn	Si	S	P	Cr	Ni	Mo	Fe
.12	4.7	.5	.01	.02	19	9	1	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Tensile Strength
 Yield Strength
 Elongation
 Impact Energy
 Hardness
 Work Hardness

Maximum Value Up to:

101,000 PSI (690 MPa)
 76,000 PSI (510 MPa)
 40%
 80J: +20°C
 Brinell 200, Rockwell C25
 Brinell 450, Rockwell C48

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	90	120
Maximum Amperage	90	120	150

Welding Techniques: Never preheat manganese steels due to crack sensitivity. Always use minimal amperage.

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)	12" (300)	.3 oz. (9g)	50 (109)	35 (76)	80	110%
1/8 (3.25)	14"(350)	.7 oz (20g)	22 (49)	21 (46)	105	110%
5/32 (4.0)	14" (350)	1 oz (29g)	15 (33)	18 (40)	135	110%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	12" (300)	14" (350)	14" (350)
Electrodes / lb	26	14	9
Electrodes / kg	58	30	19