



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

SELECTRODE
1250
NiCrMn Overlay Electrode

INTERNATIONAL CLASSIFICATIONS

Proprietary Formula – None Applicable

FEATURES & APPLICATIONS

Ideal for rebuilding and joining austenitic manganese steels and manganese steels to other steel combinations

Impact resistant electrode for joining and surfacing steels

- Deposits highly machinable alloy weld metal and designed for joining and overlaying Manganese and carbon steel parts
- High alloy deposits are very tough and will endure extreme impact and abrasion Conditions
- Operates in all positions

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Proprietary Alloy

Flux Color: Grey

C	P	Mn	Si	Cr	Ni	Fe
.8	.003	16.0	1.5	16.0	8.0	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal **Maximum Value Up to:**
Tensile Strength 116,000 PSI

Yield Strength	89,000 PSI
Hardness	Rockwell C16-19
Work Hardness	Rockwell C48

WELDING CURRENT & INSTRUCTIONS

Recommended Amperage Settings:

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	110	125	150
Maximum Amperage	135	190	250

Welding Techniques: Do not pre-heat. Use string or weave bead technique to deposit material. Avoid overheating on any manganese steel base metals.

Welding Positions: Flat, Horizontal, vertical up

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Setting	Recovery Rate
1/8 (3.25)	14" (350)	.94oz (26g)	17 (37)	22 (49)	115	160%
5/32 (4.0)	14" (350)	1.8oz (50g)	9 (19)	16 (35)	150	160%
3/16 (5.0)	14" (350)	2.7oz (75g)	6 (14)	11 (25)	210	160%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
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Length (mm)	14" (350)	14" (350)	14" (350)
Electrodes / lb	9	6	4
Electrodes / kg	20	13	9