



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 1257

All Position Chrome Carbide

INTERNATIONAL CLASSIFICATION

AWS/ASME A 5.13 E FeCr-A1

DIN 8555: E10-UM-60-GR

FEATURES & APPLICATIONS

For general overlaying on construction and mining equipment.

All position chromium carbide electrode for abrasion and medium impact

- Thinner than normal coating allows for ease of use out of position.
- Molten metal is viscous and easy to control.
- Slag is self releasing.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Austenitic alloy matrix and chromium complex carbides.

Flux Color: Dark Grey

C	Mn	Si	S	P	Cr	Ni	Cu	Fe
3.2	.14	.60	.02	.02	33	.16	.09	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Hardness

Maximum Value Up to:

Brinell 600, Rockwell C57-59

Wear Co-efficient

1.9%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: AC/DC (+)

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	90	140	180
Maximum Amperage	120	170	220

Welding Techniques: Lay down either stringer or weave beads at low amperages.

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
1/8 (3.25)	14" (350)	.8 oz (25g)	17 (37)	28 (62)	105	135%
5/32 (4.0)	14" (350)	2.2 oz (61g)	8 (17)	21 (46)	155	135%
3/16 (5.0)	14" (350)	3.2 oz (90g)	6 (13)	16 (35)	200	135%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (350)	14" (350)	14" (350)
Electrodes / lb	11	8	6
Electrodes / kg	24	17	13