



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

SELECTRODE 1258

Tubular Large Diameter
Chrome Carbide

INTERNATIONAL CLASSIFICATIONS

**NONE APPLICABLE TO THIS
PROPRIETARY PRODUCT**

FEATURES & APPLICATIONS

General wear protection on all iron base parts subject to abrasion.

Large diameter - - low amperage tubular hardfacing electrode

- Thin walled tubular construction allows for very low amperages.
- Base metal dilution is negligible and maximum hardness is achieved rapidly.
- Quickest non-automated overlaying technique.
- Special bendable aluminum grip end caps allow for easy gripping and positioning of the electrode.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: In the as-welded condition, the microstructure consists of an austenitic alloy matrix (bulk hardness RC57) and chromium/complex carbides (hardness RA 77).

Flux Color: Dark Brown

C	Ni	Cr	Si	S	P	Mn	Fe
5.4	.08	40	.59	.019	.018	1.7	bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Hardness

Maximum Value Up to:

Rockwell C 57 - 60

Vickers 665-700

Wear Co-efficient

2 %

WELDING CURRENT & INSTRUCTIONS**Recommended Current:** DC Reverse (+) or AC

Diameter (mm)	1/4 (6.5)	3/8 (9.75)	1/2 (13.0)
Minimum Amperage	80	130	180
Maximum Amperage	125	200	380

Welding Techniques: Using lowest possible amps, and while holding the electrode 10o from the vertical position, deposit either stringer or weave beads.

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
1/4 (6.5)	18" (450)	3.1 oz (87g)	5 (11)	13 (29)	100
3/8 (9.75)	18" (450)	4.4 oz (128g)	3.5 (8)	10 (22)	175
1/2 (13.0)	18" (450)	6.3 oz (176g)	2.5 (5.5)	8 (18)	215

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/4 (6.5)	3/8 (9.75)	1/2 (13.0)
Length (mm)	18" (450)	18" (450)	18" (450)
Electrodes / lb	5	4	3
Electrodes / kg	11	9	7