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

SELECTRODE 1260

Economical Hardfacing

INTERNATIONAL CLASSIFICATIONS

AWS/ASME NONE
DIN 8555: E6-UM-60-GP

FEATURES & APPLICATIONS

General hardfacing where some impact is combined with abrasion.

Economical hardfacing electrode for abrasion and moderate impact
- The best hardfacing electrode for low open circuit voltage AC welding machines.
- Spray transfer allows for smooth, uniform overlays.
- Hardness of RC 56-58 allows for good abrasion resistance along with moderate impact resistance.
- Also available as a special tubular MIG wire as Product code 7260.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: In the as-deposited condition, the microstructure consists of martensite and some carbides.

Flux Color: Grey

C	Mn	Si	P	S	Cr	Ni	Mo	Fe
.56	.95	.43	.018	.014	5.7	.03	.63	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	**Maximum Value Up to:**
Hardness	Rockwell C56-58
Wear Co-efficient	2.8%

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+), AC

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	100	150	200
Maximum Amperage	130	190	260

Welding Techniques: Weld deposits are best applied using a weave technique. Full undiluted hardness is usually achieved after 2 to 3 passes.

Welding Positions: Flat, vertical up, vertical down, horizontal, 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)	.9 oz (26g)	18 (39)	23 (50)	110	130%
5/32 (4.0)	14" (350)	2.5 oz (71g)	6 (14)	17 (37)	165	130%
3/16 (5.0)	14" (350)	3.7 oz (105g)	4 (9)	13 (29)	230	130%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (450)	14" (450)	14" (450)
Electrodes / lb	12	8	6
Electrodes / kg	26	18	13