



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

SELECTRODE
1261
Machinable Build-Up
Underlayment

INTERNATIONAL CLASSIFICATIONS

**NONE APPLICABLE TO THIS
PROPRIETARY PRODUCT**

FEATURES & APPLICATIONS

Build-up and cladding of carbon and low alloy steels. Heavy thicknesses will not crack.

Tough build-up alloy for steels offering superior compression and impact resistance

- Excellent operation on low voltage AC machines.
- Deposits easy to machine tough weldments.
- All position capabilities allows for cladding in position.
- Straight polarity (DC-) option doubles build-up speed.
- Also available as a special tubular MIG wire as Product code 7261.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

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

Flux Color: Dark Grey

C	Mn	Si	P	S	Cr	Ni	Mo	V	W	Cb	Fe
.29	.75	.61	.012	.016	1.2	.75	.14	.03	.01	.01	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal
Hardness

Maximum Value Up to:
Rockwell C33-38
Brinell 310-350
Vickers 340-380

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+), Straight (-) or AC

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	90	120	160
Maximum Amperage	110	140	180

Welding Techniques: Remove fatigued metal. Weld deposits can be made using stringer or weave technique. For very high build-ups use DC straight polarity (-).

Welding Positions: Flat, Vertical up, 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
1/8 (3.25)	14" (350)	.59 oz (17g)	27 (60)	21 (47)	115
5/32 (4.0)	14" (350)	1.1 oz (30g)	15 (32)	18 (39)	175
3/16 (5.0)	14" (350)	1.8 oz (50g)	9 (20)	13 (28)	220

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	12	8	6
Electrodes / kg	26	18	13