



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

**SELECTRODE**  
**1262**  
**Build-Up for Extreme  
Compressive Stress**

**INTERNATIONAL CLASSIFICATIONS**

**AWS – None**  
**DIN 8555: E1-UM-250**

**EN 14700 E Fe 1**

**FEATURES & APPLICATIONS**

For underlayments on carbon and low alloy steels, also as a stand alone overlay for medium hard tough build-ups on rails, shafts, etc.

High build-up electrode depositing weldmetal that resists extreme compressive stresses

- Very tough alloy for underlayments or medium hard tough overlays.
- Excellent machinability.
- Excels in vertical and horizontal position welding.

**ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)**

**Microstructure:** Martensite with some carbides.

**Flux Color:** Grey

C	Mn	Si	S	P	Cr	Ni	Mo	Fe
.08	1.85	.65	.012	.01	1.4	.72	.14	bal

**TYPICAL MECHANICAL PROPERTIES**

**Undiluted Weld Metal**

Hardness:

**Maximum Value Up to:**

Rockwell C 25-27 Brinell 270

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

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	100	140	180
Maximum Amperage	140	180	230

**Welding Techniques:** Weld in a stringer or 3 x weave fashion. When welding vertically use the "whip" technique.**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 Settings
1/8 (3.25)	18" (450)	.77 oz (22g)	20 (44)	21 (47)	120
5/32 (4.0)	18" (450)	1.33 oz (39g)	12 (26)	18 (39)	160
3/16 (5.0)	18" (450)	2.34 oz (65g)	7 (15)	13 (28)	205

**APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS**

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	18" (450)	18" (450)	18" (450)
Electrodes / lb	9	6	5
Electrodes / kg	21	14	11