



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

**SELECTRODE**  
**1263**  
**Metal to Metal Wear**  
**Resistance**

**INTERNATIONAL CLASSIFICATIONS**

**AWS – None**  
**DIN 8555: E6-UM-60**

**EN 14700 E Fe8**

**FEATURES & APPLICATIONS**

Especially suited for metal to metal wear applications involving steel, manganese steel and cast iron.

Wear facing electrode for impact and moderate abrasion

- Excellent welding characteristics.
- Deposits are very crack resistant.
- Multiple layers are easily applied for thick build-ups.

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

**Microstructure:** Martensite with some dispersed carbides.

**Flux Color:** Grey

| C   | Mn | Si  | S   | P   | Cr  | Fr  |
|-----|----|-----|-----|-----|-----|-----|
| .65 | .5 | 1.2 | .04 | .03 | 9.3 | bal |

**TYPICAL MECHANICAL PROPERTIES**

**Undiluted Weld Metal**

Hardness:

**Maximum Value Up to:**

Vickers 650

Rockwell C58-60

**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 | 80         | 110        | 140        |
| Maximum Amperage | 120        | 160        | 180        |

**Welding Techniques:** No preheat required. Remove all loose and foreign matter. Deposit stringer or weave beads using a short arc length.

**Welding Positions:** Flat, Horizontal

**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)   | 1.1 oz (31g)         | 14 (30)                             | 23 (50)                            | 120               | 130%          |
| 5/32 (4.0)    | 14" (350)   | 2.7 oz (76g)         | 6 (14)                              | 17 (37)                            | 175               | 130%          |
| 3/16 (5.0)    | 14" (350)   | 4 oz (112g)          | 4 (9)                               | 13 (29)                            | 250               | 130%          |

**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 | 8          | 6          | 5          |
| Electrodes / kg | 18         | 13         | 11         |