



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

SELECTRODE 1265

Smooth Overlay RC 66 to 68

INTERNATIONAL CLASSIFICATIONS

DIN 8555: E10-UM-65-G

FEATURES & APPLICATIONS

For conveyor screws, mixer blades, pump and crusher parts operation in sand, clay, cement, and coal.

For abrasion resistance and moderate impact resistance

- Basic coated SMAW electrode for hardsurfacing.
- Good for severe abrasion and moderate impact resistance.
- Suitable up to 500° C.
- 120% Recovery.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Si	Cr	Mo	Fe
4.3	0.4	0.7	10.2	1.9	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Structure
Hardness

Maximum Value Up to:

Martensitic cast iron
1 layer 59 HRc
2 layers 61 HRc

	3 layers 65 HRc
	4 layers 67 HRc
Wear Coefficient	2% (SiO ₂ as abrasive)
Machinability	Grinding only

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Straight (-), AC

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	85	115	150
Maximum Amperage	120	150	190

Welding Techniques: Select the minimum required amperage and utilize a medium arc gap. For smooth flat welds use a 3 x weave. There is minimal slag which can be overwelded without prior removal. Only 2 passes are required for development of the full benefits of this alloy. Cross crack stress relieving is normal.

Welding Positions: Flat, Horizontal, Half up

Deposition Rates:

Diameter (mm)	Length (mm)	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)
1/8 (3.25)	14" (350)	19 oz (43g)	41 (90)
5/32 (4.0)	14" (350)	12 oz (27g)	27 (60)
3/16 (5.0)	14" (350)	8 oz (18g)	19 (42)

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	10	9
Electrodes / kg	26	22	20