



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

# SELECTRODE 1268

All Position Shock and  
Abrasion Resistance

## INTERNATIONAL CLASSIFICATIONS

AWS – None  
DIN 8555: E6-UM-60

EN 14700 E Fe6

## FEATURES & APPLICATIONS

Excellent for restoring worn hammers and assorted parts in rock crushing equipment.

All position shock and abrasion resistant electrode

- Excellent for overlaying in vertical and horizontal positions.
- Unusual ability to resist both shock and abrasion.
- Up to 10 pass build-ups without weld cracking.
- Welds pass over pass without chipping slag.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Microstructure:** Martensite with some carbides.

**Flux Color:** Grey

C	Mn	Si	S	P	Cr	Mo	Ni	Fe
.5	.4	2.4	.012	.01	9.0	.02	.08	bal

## TYPICAL MECHANICAL PROPERTIES

**Undiluted Weld Metal**

Hardness:

Wear Co-efficient:

**Maximum Value Up to:**

Rockwell C 56-57

2.2%

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

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	80	100	140	180
Maximum Amperage	100	140	180	230

**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, 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
3/32 (2.5)	14" (350)	.39 oz (11g)	41 (90)	36 (79)	90
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)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (350)	18" (450)	18" (450)	18" (450)
Electrodes / lb	21	9	6	5
Electrodes / kg	46	21	14	11