



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

SELECTRODE 1279 Chromium Carbide

INTERNATIONAL CLASSIFICATION

AWS/ASME NONE

FEATURES & APPLICATIONS

Medium hardness chromium carbide for protecting most iron base surfaces against abrasive wear and impact.

Chromium carbide electrode for economical smooth overlays

- 3/32(2.5mm) and 1/8(3.2mm) provide position capability.
- Typically used on dredge pump shells and components, crusher rolls and gyratory cones.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: In the as-welded condition, the microstructure consists of chrome carbides in a semi-austenitic matrix.

Flux Color: Grey

C	Ni	Mn	Mo	Si	S	P	Cr	Fe
1.8	3	.30	1.50	.60	.019	.017	30	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Maximum Value Up to:

TDS 1279 – Revision 06/15/15

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	65	110	160	210
Maximum Amperage	95	140	200	270

Welding Techniques: Use a stringer or wide weave technique. Deposit a maximum of 2 to 3 passes to achieve full hardness.

Welding Positions: Flat, Horizontal (smaller diameters can be used out of position)

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
3/32 (2.5)	14" (350)	.76 oz (21g)	21 (47)	32 (71)	80	180%
1/8 (3.25)	14" (350)	1.1 oz (31g)	14 (30)	23 (50)	120	180%
5/32 (4.0)	14" (350)	2.7 oz (76g)	6 (14)	17 (37)	175	180%
3/16 (5.0)	14" (350)	4 oz (112g)	4 (9)	13 (29)	250	180%

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)	14" (350)	14" (350)	14" (350)
Electrodes / lb	15	9	6	4
Electrodes / kg	33	20	13	9