



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

# SELECTRODE 1283

Tin Bronze DC Electrode

## INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.6 E CuSn - C

DIN 1733: EL – CuSn7

## FEATURES & APPLICATIONS

Repairing bronze parts, especially those that are subject to sea water and many other chemicals.

A special tin-bronze electrode for joining and surfacing on DC (+)

- Tin content makes deposits harder and more wear resistant.
- Deposits are uniform and porosity free.
- Slag is easy to remove.
- Also available in TIG form as item #6008

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Microstructure:** A multi-phase copper base structure with complex eutectoids.

**Flux Color:** Light Grey

Sn	Fe	P	Al	Mn	Pb	Si	Ni	Other	Cu
8	.1	.1	.01	.01	.02	.05	.05	.50	Bal

## TYPICAL MECHANICAL PROPERTIES

<b>Undiluted Weld Metal</b>	<b>Maximum Value Up to:</b>
Tensile Strength	58,000 PSI (410 MPa)
Yield Strength	42,000 PSI (290 MPa)
Elongation	33%
Hardness	Brinell 107

## WELDING CURRENT & INSTRUCTIONS

### Recommended Current: DC Reverse (+)

Diameter (mm)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	100	125
Maximum Amperage	150	190

**Welding Techniques:** Bevel edges of heavy sections. Preheat is not usually required. Maintain a medium arc length. Allow to cool before chipping slag.

**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
1/8 (3.25)	14" (350)	.8 oz. (22g)	20 (45)	25 (54)	125
5/32 (4.0)	14"(350)	1.1 oz (32g)	14 (31)	16 (36)	155

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	1/8 (3.25)	5/32 (4.0)
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Length (mm)	14" (350)	14" (350)
Electrodes / lb	13	9
Electrodes / kg	29	20