



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

SELECTRODE 1284

Nickel Manganese Aluminum
Bronze Electrode

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.6 E CuMnNiAl
DIN 1733: EL-CuMn14Al

FEATURES & APPLICATIONS

Joining and surfacing parts subject to service in marine environments and seawater.

Very high strength nickel manganese aluminum bronze electrode with excellent wear resistance.

- Universal electrode safely repairs all grades of aluminum bronzes.
- Resists corrosion, cavitation, erosion, and metal to metal wear.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Complex alpha matrix with kappa compound phases and some retained beta phase.

Flux Color: Grey

Mn	Si	Ni	Fe	Pb	Al	Cu
12.7	.6	2.3	3	.02	6.6	Bal

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal
Tensile Strength

Maximum Value Up to:
96,000 PSI (650 MPa)

Yield Strength	65,000 PSI (450 MPa)
Elongation	20%
Hardness	Brinell 155, Rockwell B87

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Reverse (+)

Diameter (mm)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	90	105	135
Maximum Amperage	130	155	210

Welding Techniques: Preheat is not required. Maintain a short arc gap. Clean slag thoroughly between passes.

Welding Positions: Flat

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)	110
5/32 (4.0)	14"(350)	1.1 oz (32g)	14 (31)	16 (36)	135
3/16 (5.0)	14" (350)	1.6 oz (45g)	10 (22)	13 (28)	180

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	13	9	6
Electrodes / kg	29	20	13