



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

# SELECTRODE 1285

Aluminum Bronze Electrode

## INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.6 E CuAl-A2

DIN 1733: EL - CuAl9

## FEATURES & APPLICATIONS

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

Very high strength 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.
- Also excellent for overlays on cast irons, steels and copper.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

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

**Flux Color:** Grey

Fe	Si	Al	Pb	Cu
3.2	1.4	8	.02	Bal

## TYPICAL MECHANICAL PROPERTIES

**Undiluted Weld Metal**

Tensile Strength

**Maximum Value Up to:**

89,000 PSI (614 MPa)

Yield Strength	59,000 PSI (407 MPa)
Elongation	23%
Hardness	Brinell 148, Rockwell B82

## 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, 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)	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