



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 1286 Silicon Bronze

INTERNATIONAL CLASSIFICATIONS

AWS A5.13 ECuSi

FEATURES & APPLICATIONS

The 1286 is used for welding copper-zinc alloys. It is also used for welding silicon bronze, copper and galvanized steel.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Flux Color: Grey

Sn	Mn	Fe	Si	Cu
.08	.80	.30	3.0	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	55,000 PSI (379 N/mm ²)
Yield Strength	25,000 PSI (172 N/mm ²)
Elongation	50%
Hardness	90 HB

WELDING CURRENT & INSTRUCTIONS

Recommended Current: DC Straight (-) or AC

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	75	100	120
Maximum Amperage	105	135	160

Welding Techniques: Remove all surface contamination from weld area. Maintain a short arc gap and fill in craters prior to extinguishing the arc.