



Manufacturers of Custom Welding Lines for Resale  
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# SELECTRODE 1293

Bare Cobalt Grade 21

## INTERNATIONAL CLASSIFICATIONS

**AWS A5.21 ERCoCr-E**

## FEATURES & APPLICATIONS

1293 deposits have very good strength and ductility in temperatures up to 2100°F. Deposits are resistant to thermal shock, oxidizing and reducing atmospheres. The deposit is a solid solution strengthened alloy with a relatively low weight-percent carbide phase in the microstructure making this alloy very tough with work hardening characteristics.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Fe	Si	Cr	W	Ni	Mo	Co
0.24	0.8	1.7	0.8	27.4	0.17	2.73	5.4	Bal.

## TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	103,000 PSI (710 N/mm <sup>2</sup> )
Yield Strength	82,000 PSI (565 N/mm <sup>2</sup> )
Elongation	9%
Hardness	30-35 RC

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Straight (-) Gas: 100% Argon

Diameter (mm)	1/16 (1.6)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	55	75	90	120

Maximum Amperage	90	100	120	140
Volts	15-25	15/25	15-30	15-30