



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

# SELECTRODE 1295

Bare Cobalt Grade 25

## INTERNATIONAL CLASSIFICATIONS

None

## FEATURES & APPLICATIONS

1295 deposits offer combined resistance to impact, heat, abrasion, corrosion, scaling and thermal shock. It has resistance to scaling up to 1800°F. The weld deposits have excellent corrosion resistance in oxidizing atmospheres and chlorine type solutions. Commonly used to repair press forging dies, hot trimming dies, punching shearing dies, extrusion dies, dummy blocks and gas turbine engines. This alloy work hardens rapidly.

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Fe	Si	Cr	W	Ni	Mo	Co
0.1	1.5	2.1	0.8	20	15	10	.14	Bal.

## TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	150,000 PSI (1034N/mm <sup>2</sup> )
Elongation	45%
Hardness (As welded)	25 RC
Work Hardness	45 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