



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

# SELECTRODE 1256

Air Hardening Tool  
Steel Electrode

## INTERNATIONAL CLASSIFICATIONS

**AWS/ASME: NONE**

**EN14700 EFe6**

**DIN 8555: E6-UM – 60**

## FEATURES & APPLICATIONS

Ideal for repairing and rebuilding shear blades, percussion drills, earth borers, crusher jaws, etc.

Unique alloy for repair & build-up of all Air Hardening tool steels.

- Deposits are highly crack resistant, forgeable and temperable.
- High alloy deposits are very tough and will endure extreme impact and abrasion conditions.
- Operates in all positions.
- Also available in TIG form as item #6115

## ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Microstructure:** Tempered Martensite

**Flux Color:** Grey

C	P	Mn	Si	Cr	Ni	Mo	S
.37	.012	.22	1.45	8.08	0.11	0.02	.008

## TYPICAL MECHANICAL PROPERTIES

**Undiluted Weld Metal**  
Hardness

**Maximum Value Up to:**  
Rockwell C55-60

## WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** AC, DC + or -

Diameter (mm)	3/32 (2.4)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Minimum Amperage	45	80	130	150
Maximum Amperage	90	120	160	175

**Welding Techniques:** Do not pre-heat. Use string or weave bead technique to deposit material. Avoid overheating on any manganese steel base metals.

**Welding Positions:** Flat, horizontal, vertical up

**Deposition Rates:**

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings	Recovery Rate
3/32 (2.4)	14"(350)	.94 oz (26g)	17 (37)	22 (49)	80	120%
1/8 (3.25)	14" (350)	.94 oz (26g)	17 (37)	22 (49)	115	120%
5/32 (4.0)	14"(350)	1.8 oz (50g)	9 (19)	16 (35)	150	120%
3/16 (5.0)	14" (350)	2.7 oz (75g)	6 (14)	11 (25)	170	120%

## APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)	3/16 (5.0)
Length (mm)	14" (350)	14" (350)	14" (350)	14" (350)
Electrodes / lb	20	13	9	6
Electrodes / kg	44	28	20	13