



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE
1291
Bare Cobalt Grade 1

INTERNATIONAL CLASSIFICATIONS

AWS A5.21 ERCoCr-C

FEATURES & APPLICATIONS

1291 is a hard surfacing alloy possessing excellent abrasion and corrosion resistance for applications such as pump sleeves, rotary seal rings, wear pads, expeller screws and bearing sleeves. It retains its hardness at temperatures in excess of 1400°F (760°C). It bonds well to all weldable steels, including stainless steel.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Fe	Si	Cr	W	Ni	Mo	Co
2.2	.10	2.5	1.0	29.5	12.4	2.4	.10	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal	Maximum Value Up to:
Tensile Strength	79,000 PSI (545 N/mm ²)
Elongation	<1%
Hardness	53-54 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