



Tech-Rod 112LFe

(Low Iron)

Description: Tech-Rod 112LFe is a low iron version of the standard Tech-Rod 112 covered electrode which is used to weld nickel-chromium-molybdenum alloys. It is used extensively in overlay cladding where similar chemical composition is required on the clad side. These electrodes are used in applications where the temperature ranges from cryogenic up to 1800°F. The deposit chemistry is similar to a 625 solid wire and is certified to contain less than 1% Iron (Fe) in an undiluted application.

Specifications & Approvals:

AWS A5.11:2010 ENiCrMo-3

UNS W86112

ASME QSC-395

CWB

Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	W	S	P	Ti	Al	Other
.02	.3	.3	0.8	22.0	9.0	63	3.5		.003	.005			

Typical Mechanical Properties

Tensile Strength	112,000 PSI	772 MPa
Yield Strength	89,500 PSI	620 MPa
Elongation	34%	

Welding Parameters

Process	Diameter x Length	Voltage	Amperage	
			Flat	Vertical & Overhead
SMAW	3/32" (2.4mm) x 12" (305mm)	24-28	70-85	65-75
	1/8" (3.2mm) x 14" (355mm)	26-30	85-110	80-90
	5/32" (4.0mm) x 14" (355mm)	28-32	110-140	100-120
	3/16" (4.8mm) x 14" (355mm)	28-32	120-160	110-130

Standard Packages:

3/32" Diameter	8 Lb (3.6Kg) Can	24 Lb (10.9Kg) Master Carton	26 Electrodes per Lb
1/8" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	14 Electrodes per Lb
5/32" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	9 Electrodes per Lb
3/16" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	6 Electrodes per Lb