

TECH-ROD 122

I. DESCRIPTION: Tech-Rod 122 electrodes are used for welding of nickel-chromium-molybdenum alloys as well as for overlay cladding on carbon, low alloy, or stainless steels. They are also used for dissimilar joints between nickel-chromium-molybdenum alloys and stainless, carbon, or low alloy steels. Typical specifications for the nickel-chromium-molybdenum base metals are ASTM, B574, B619, and B626--all of which have UNS Number N06022. Tech-Rod 122 offers excellent corrosion resistance in oxidizing as well as reducing media in a wide variety of chemical process environments. It offers an outstanding resistance to stress corrosion cracking, pitting, and crevice corrosion.

II. APPROVALS: Manufactured under Quality System approved by ASME, ISO9001. Meets AWS 5.11 Class ENiCrMo-10. Approved by Canadian Welding Bureau.

III. CHEMICAL COMPOSITION

Carbon	.014
Manganese	.35
Silicon	.16
Chromium	21.2
Molybdenum	13.1
Tungsten	3.3
Sulfur	.005
Phosphorus	.012
Iron	3.9
Nickel	Balance

MECHANICAL PROPERTIES

Tensile Strength	
114,000 PSI	790 MPA
Yield Strength	
78,500 PSI	540 MPA
Elongation	
36%	
Impact Strength	
@-196°C	60 ft/lbs
Lateral Expansion	
44 Mils	

IV. WELDING PARAMETERS

Direct Current
Electrode + Ve

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

V. PACKAGES AVAILABLE:

3/16"-10# can, 5/32"-10# can, 1/8"-10# Can, 3/32"-8# can