

TECH-ROD 135

I. **DESCRIPTION:** Tech-Rod 135 is a covered electrode which is used for welding of nickel-iron-chromium-molybdenum-copper alloys. This electrode can be used to weld dissimilar joints between nickel alloys and stainless steels or low alloy steels as well as for overlay cladding where similar chemical composition is required.

II. **APPROVALS:** Manufactured under Quality System approved by ASME, ISO9001.

III. **CHEMICAL COMPOSITION**

Carbon	.02
Manganese	2.1
Silicon	.40
Iron	27.4
Chromium	29.3
Molybdenum	3.2
Copper	1.8
Phosphorus	.009
Sulfur	.005
Nickel	35.2

MECHANICAL PROPERTIES

Tensile Strength	
87,000 PSI	600 MPA
Yield Strength	
71,000 PSI	490 MPA
Elongation	33%

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