

TECH-ROD 141

- I. **DESCRIPTION:** Tech-Rod 141 is used for welding of cast and wrought forms of commercially pure nickel. These electrodes can also be used for surfacing as well as dissimilar welding between nickel and steel or stainless steel. The weld metal of this electrode has excellent corrosion resistance to caustic alkalies such as caustic soda and caustic potash.
- II. **APPROVALS:** Manufactured under Quality System approved by ASME, ISO9001. Meets AWS 5.11 Class ENi-1

III. **CHEMICAL COMPOSITION**

Carbon	.04
Manganese	.45
Silicon	.50
Iron	.35
Titanium	1.05
Phosphorus	.01
Sulfur	.005
Nickel	97.6

MECHANICAL PROPERTIES

Tensile Strength	
64,500 PSI	500 MPA
Yield Strength	
58,500 PSI	400 MPA
Elongation	26%

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