

TECH-ROD 187

- I. **DESCRIPTION:** Tech-Rod 187 is a copper-nickel, all-position electrode for shielded metal arc welding of wrought or cast alloys of similar composition as well as 80 Cu + 20 Ni and 90 Cu + 10 Ni alloys. It is also used for the clad side of copper-nickel clad steels. This filler metal is widely used in marine applications because of its good resistance to the corrosive effects of sea water.
- II. **APPROVALS:** Manufactured under Quality System approved by ASME, ISO9001. Meets AWS 5.6 Class CuNi.

III. **CHEMICAL COMPOSITION**

Nickel	30.5
Manganese	1.8
Silicon	.35
Iron	.62
Sulfur	.004
Phosphorus	.009
Lead	.002
Titanium	.2
Copper	Balance

MECHANICAL PROPERTIES

Tensile Strength	
54,500 PSI	380 MPA
Yield Strength	
37,500 PSI	260 MPA
Elongation:	28%

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