

# TECH-ROD WELD A

I. DESCRIPTION: Tech-Rod Weld A electrodes are used for welding of nickel-chromium-iron alloys to themselves as well as for dissimilar welding between various nickel alloys and carbon or stainless steels. These electrodes can also be used for overlay cladding where similar alloy is needed. These electrodes have wide applications ranging from cryogenic temperatures up to 1500°F.

II. APPROVALS: Manufactured under Quality System approved by ASME, ISO9001. Meets AWS A5.11, Class ENiCrFe-2.

III. CHEMICAL COMPOSITION

Carbon	.04
Manganese	1.75
Silicon	.32
Chromium	15.5
Molybdenum	1.5
Columbium+Tantalum	1.25
Iron	8.5
Phosphorus	.009
Sulfur	.006
Nickel	71.15

MECHANICAL PROPERTIES

<b>Tensile Strength</b>	
89,000 PSI	610 MPA
<b>Yield Strength</b>	
72,000 PSI	500 MPA
<b>Elongation</b>	
36%	

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