

TECH-ROD® 112LFE

Nickel ■ AWS ENiCrMo-3

KEY FEATURES

- A low iron version of the standard Tech-Rod® 112 covered electrode which is used to weld nickel-chromium-molybdenum alloys
- The product is designed to have less than 1% Iron (Fe) for overlay applications to minimize dilution of parent metal iron in the deposit

CONFORMANCES

AWS A5.11/A5.11M: 2010 ENiCrMo-3
UNS W86112
ASME SFA-5.11 ENiCrMo-3

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	10 lb (4.5 kg) Can 30 lb (13.6 kg) Master Can
1/8 (3.2)	14 (355)	EL112LFE125634
5/32 (4.0)	14 (355)	EL112LFE156634
3/16 (4.8)	14 (355)	EL112LFE187634

MECHANICAL PROPERTIES - As Required per AWS A5.11/A5.11M: 2010

	Tensile Strength Mpa (ksi)	Elongation %
Requirements AWS A5.11/A5.11M:2010	690 (110 min)	30 min
Typical Performance Tech-Rod® 112LFe	770 (111)	42

DEPOSIT COMPOSITION⁽¹⁾ - As Required per AWS A5.11: 2010

	%C	%Mn	%Fe	%P	%S	%Si
Requirements AWS ENiCrMo-3	0.10 max	1.0 max	7.0 max	0.03	0.02 max	0.75 max
Typical Performance⁽²⁾ Tech-Rod® 112LFe	0.02	0.5	0.9	0.01	0.01	0.3
	%Cu	%Ni	%Cr	%Nb+Ta	%Mo	%Other
Requirements AWS ENiCrMo-3	0.50 max	55.00 min	20.0 - 23.0	3.15 - 4.15	8.0 - 10.0	0.50 max
Typical Performance⁽²⁾ Tech-Rod® 112LFe	0.01	62.7	22.5	3.72	8.7	—

TYPICAL OPERATING PROCEDURES

Diameter in (mm)	Length in (mm)	Amperage	
		Flat	Vertical & Overhead
1/8 (3.2)	14 (355)	85-110	80-90
5/32 (4.0)	14 (355)	110-140	110-120
3/16 (4.8)	14 (355)	120-160	110-130

⁽¹⁾Typical all wire chemistry. ⁽²⁾See test results disclaimer on pg. 13.Safety Data Sheets (SDS) are available on our website at www.lincolnelectric.com