

TECH-ROD® 122

Nickel ■ AWS ENiCrMo-10

KEY FEATURES

- Excellent corrosion resistance in oxidizing as well as reducing media in a wide variety of chemical process environments
- Offers an outstanding resistance to stress corrosion cracking, pitting and crevice corrosion
- Better corrosion resistance than 276 and 625
- Q2 Lot® - certificates showing actual deposit composition available online

CONFORMANCES

AWS A5.11/A5.11M: 2010 ENiCrMo-10
ASME SFA-A5.11 ENiCrMo-10
UNS W86122

TYPICAL APPLICATIONS

- Used for welding of nickel-chromium-molybdenum alloys as well as for overlay cladding on carbon, low alloy or stainless steels
- Used for dissimilar joints between nickel-chromium-molybdenum alloys and stainless, carbon or low alloy steels

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	8 lb (3.6 kg) Can 24 lb (10.9 kg) Master Can	10 lb (4.5 kg) Can 30 lb (13.6 kg) Master Can
3/32 (2.4)	12 (305)	EL122093632	EL122125634 EL122156634
1/8 (3.2)	14 (355)		
5/32 (4.0)	14 (355)		

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)	25 min
Typical Performance Tech-Rod® 122	730 (105)	39

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

	%C	%Mn	%Fe	%P	%S
Requirements AWS ENiCrMo-10	0.02 max	1.0 max	2.0 - 6.0	0.03 max	0.015 max
Typical Performance⁽²⁾ Tech-Rod® 122	0.02	0.4	4.8	0.01	0.004
	%Si	%Cu	%Ni	%Co	%Cr
Requirements AWS ENiCrMo-10	0.2 max	0.50 max	Remainder	2.5 max	20.0 - 22.5
Typical Performance⁽²⁾ Tech-Rod® 122	0.1	0.001	56.7	0.014	21.0
	%Nb+Ta	%Mo	%V	%W	%Other
Requirements AWS ENiCrMo-10	Not Specified	12.5 - 14.5	0.35 max	2.5 - 3.5	0.50 max.
Typical Performance⁽²⁾ Tech-Rod® 122	0.008	13.4	0.01	3.4	—

TYPICAL OPERATING PROCEDURES

Diameter in (mm)	Length in (mm)	Amperage	
		Flat	Vertical & Overhead
3/32 (2.4)	12 (305)	70-85	65-75
1/8 (3.2)	14 (355)	85-110	80-90
5/32 (4.0)	14 (355)	110-140	100-120

⁽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