TECH-ROD® 141

Nickel ▪ AWS ENi-1

KEY FEATURES

- Q2 Lot® - certificates showing actual deposit composition available online
- High nickel alloy

CONFORMANCES

AWS A5.11/A5.11M: 2010	ENi-1
ASME SFA-A5.11	ENi-1
UNS	W82141

TYPICAL APPLICATIONS

- Used for joining Cu-Ni to stainless steels
- Welding of cast and wrought forms of pure Nickel alloys

DIAMETERS / PACKAGING

Diameter in	Diameter (mm)	Length in (mm)	8 lb (3.6 kg) Can 24 lb (10.9 kg) Master Carton	10 lb (4.5 kg) Can 30 lb (13.6 kg) Master Can
3/32	(2.4)	12 (305)	EL141093632	
1/8	(3.2)	14 (355)		EL141125634
5/32	(4.0)	14 (355)		EL141156634
3/16	(4.8)	14 (355)		EL141187634

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

	Tensile Strength Mpa (ksi)	Elongation %
Requirements AWS A5.11/A5.11M:2010	410 (60 min)	20 min
Typcial Performance Tech-Rod® 141	430 (63)	21

DEPOSIT COMPOSITION[1] - *As Required per AWS A5.11/A5.11M: 2010*

	%C	%Mn	%Fe	%P	%S	%Si
Requirements AWS ENi-1	0.10 max	0.75 max	0.75 max	0.03 max	0.02 max	1.25 max
Typical Performance[2] Tech-Rod® 141	0.02	0.30	0.40	0.01	0.01	0.48
	%Cu	**%Ni**	**%Ti**	**%Al**	**%Other**	
Requirements AWS ENi-1	0.25 max	92.0 min	1.0 - 4.0	1.0 max	0.50 max.	
Typical Performance[2] Tech-Rod® 141	0.01	96.7	1.2	0.03	–	

TYPICAL OPERATING PROCEDURES

Diameter in (mm)	Length in (mm)	Amperage Flat	Amperage 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
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