

TECH-ROD® 187

Nickel ▪ AWS ECuNi

KEY FEATURES

- A copper-nickel electrode for welding alloys of similar composition as well as 80/20 and 90/10 Cu/Ni alloys
- Q2 Lot® - certificates showing actual deposit composition available online

CONFORMANCES

AWS A5.6/A5.6M: 2008	ECuNi
ASME SFA-A5.11	ECuNi
UNS	W60715

TYPICAL APPLICATIONS

- Marine applications
- Good resistance to the corrosive effects of sea water
- Used for the clad side of copper-nickel clad steels

DIAMETERS / PACKAGING

Diameter in (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)	EL187093632	EL187125634
1/8 (3.2)	14 (355)		

MECHANICAL PROPERTIES - As Required per AWS A5.6/A5.6M: 2008

	Tensile Strength Mpa (ksi)	Elongation %
Requirements AWS A5.11/A5.11M:2010	345 (50 min)	20 min
Typical Performance Tech-Rod® 187	360 (52)	24

DEPOSIT COMPOSITION⁽¹⁾ - As Required per AWS A5.6: 2008

	%Mn	%Fe	%P	%Si	%Cu
Requirements AWS ECuNi	1.00 - 2.50	0.40 - 0.75	0.020 max	0.50 max	Remainder
Typical Performance⁽²⁾ Tech-Rod® 187	1.58	0.60	0.001	0.01	63.0
	%Ni	%Ti	%Pb	%Other	
Requirements AWS ECuNi	29.0 - 33.0	0.50 max	0.02 max	0.50 max	
Typical Performance⁽²⁾ Tech-Rod® 187	30.4	0.24	0.001	<0.50	

TYPICAL OPERATING PROCEDURES

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

⁽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