

TECH-ROD® WELD A

Nickel ■ AWS ENiCrFe-2

KEY FEATURES

- Overlay cladding where a similar composition is needed
- Q2 Lot® - certificates showing actual deposit composition available online

CONFORMANCES

AWS A5.11/A5.11M: 2010 ENiCrFe-2
UNS W86133

TYPICAL APPLICATIONS

- For dissimilar welds between nickel-chromium-iron alloys to mild steels or stainless steels
- Furnace equipment
- Petrochemical plants

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)	ELWLDA093632	ELWLDA125634 ELWLDA156634 ELWLDA187634
1/8 (3.2)	14 (355)		
5/32 (4.0)	14 (355)		
3/16 (4.8)	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	550 (80 min)	30 min
Typical Performance Tech-Rod® Weld A	650 (94)	42

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

	%C	%Mn	%Fe	%P	%S	%Si
Requirements AWS ENiCrFe-2	0.10 max	1.0 - 3.5	12.0 max	0.03 max	0.02 max	0.75 max
Typical Performance⁽²⁾ Tech-Rod® Weld A	0.04	2.6	10.0	0.012	0.004	0.40
	%Cu	%Ni	%Cr	%Nb+Ta	%Mo	%Other
Requirements AWS ENiCrFe-2	0.50 max	62.0 min	13.0 - 17.0	0.5 - 3.0	0.5 - 2.5	0.50 max
Typical Performance⁽²⁾ Tech-Rod® Weld A	0.06	67	15	2.0	0.96	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
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