



## Alloy 112 Welding Electrodes

**CLASSIFICATIONS:** AWS A5.11/ASME SFA 5.11 Class ENiCrMo-3 UNS W86112

**DESCRIPTION:** Alloy 112 welding electrodes are used for SMAW welding of alloy 625, 825, 25-6Mo and other NiCrMo alloys. It is also used in corrosion resistant applications and for surfacing of steel. The weld metal has high strength at room and elevated temperatures. Alloy 112 resists pitting, crevice corrosion, and polythionic acid stress corrosion cracking. Dissimilar applications include NiCrMo alloys to stainless steel, low alloy and carbon steels.

### TYPICAL DEPOSIT CHEMISTRY:

C	Cr	Ni	Mo	Mn	Si	P	S	Fe	Cu	Nb+Ta	Others
.02	22.5	64.0	9.0	.50	.32	.01	.003	.50	.01	4.0	<.50

### TYPICAL MECHANICAL PROPERTIES:

<b>Tensile Strength</b>	114,000 psi (790 MPa)
<b>Elongation</b>	42%

### TYPICAL OPERATING PARAMETERS:

Diameter (in/mm)	Amperage	
	Flat	Vertical & Overhead
3/32" (2.4mm)	70-85	65-75
1/8" (3.2mm)	85-110	80-90
5/32" (4.0mm)	110-140	110-120
3/16" (4.8mm)	120-160	110-130

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.