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:

Tensile Strength	114,000 psi (790 MPa)
Elongation	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