



Supplier of Welding Alloys

## Nickel Alloy Coated Electrodes

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### Oxford Alloy® 190

#### SPECIFICATIONS

AWS 5.11  
ASME SFA 5.11

#### CLASSIFICATIONS

AWS ENiCu-7  
UNS W84190

#### DESCRIPTION / APPLICATION

Oxford Alloy 190 is used for shielded-metal-arc welding of Monel® alloys 400, R-405, and K-500. This electrode is also used for surfacing of steel. The weld metal of the Oxford Alloy 190 is resistant to corrosion by seawater, salts, and reducing acids. The electrode is capable of producing weld deposits that meet stringent radiographic requirements. Dissimilar-welding applications for welding Oxford Alloy 190 include joints between Monel®, nickel-copper alloys and carbon steel, low-alloy steel, copper, and copper-nickel alloys. Oxford Alloy 190 produces sound joints in Monel® alloy K-500, the weld metal has lower strength since, unlike the base metal, it is not age hardenable. This electrode can be operated in all welding positions.

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AWS Chemical Composition						
Ni	C	Mn	Fe	S	Si	Cu
62.0-69.0	0.15 max	4.0 max	2.5 max	0.015 max	1.5 max	Bal
Al	Ti	P	OET			
0.75 max	1.0 max	0.02 max	0.50 max			

#### TYPICAL MECHANICAL PROPERTIES

Tensile strength: 75,500 psi 520 MPa  
Yield strength: 52,000 psi 360 MPa  
Elongation: 39%

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Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

Data contained in this publication are typical of the products and properties described, but are not suitable for specifications.  
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