



# Tech-Rod 122

**Description:** Tech-Rod 122 electrodes are used for welding of nickel-chromium-molybdenum alloys as well as for overlay cladding on carbon, low alloy or stainless steels. They are also used for dissimilar joints between nickel-chromium-molybdenum alloys and stainless, carbon or low alloy steels. Tech-Rod 122 offers excellent corrosion resistance in oxidizing as well as reducing media in a wide variety of chemical process environments. It offers an outstanding resistance to stress corrosion cracking, pitting and crevice corrosion. It is similar to 276 with higher chromium content.

## Specifications & Approvals:

**AWS A5.11:2010 ENiCrMo-10      UNS W86022      ASME QSC-395      CWB**

## Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	W	S	P	Ti	Al	Other
.01	.4	.15	2.5	22.	13.5	Rem		3.1	.003	.06			

## Typical Mechanical Properties

Tensile Strength	114,000 PSI	790 MPa
Yield Strength	78,500 PSI	540 MPa
Elongation	36%	

## Welding Parameters

Process	Diameter x Length	Voltage	Amperage	
			Flat	Vertical & Overhead
SMAW	3/32" (2.4mm) x 12" (305mm)	24-28	70-85	65-75
	1/8" (3.2mm) x 14" (355mm)	26-30	85-110	80-90
	5/32" (4.0mm) x 14" (355mm)	28-32	110-140	100-120
	3/16" (4.8mm) x 14" (355mm)	28-32	120-160	110-130

## Standard Packages:

3/32" Diameter	8 Lb (3.6Kg) Can	24 Lb (10.9Kg) Master Carton	26 Electrodes per Lb
1/8" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	14 Electrodes per Lb
5/32" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	9 Electrodes per Lb
3/16" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	6 Electrodes per Lb