



Tech-Rod 141

Description: Tech-Rod 141 is used for welding of cast and wrought forms of commercially pure nickel. These electrodes can also be used for surfacing as well as dissimilar welding between nickel and steel or stainless steel.

Specifications & Approvals:

AWS A5.11:2010 ENi-1

UNS W82141

ASME QSC-395

Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	W	S	P	Ti	Al	Cu
.02	.4	.7	.5			97			.005	.01	1.3	.02	.04

Typical Mechanical Properties

Tensile Strength	64,500 PSI	500 MPa
Yield Strength	58,500 PSI	400 MPa
Elongation	26%	

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