



Tech-Rod 187

Description: Tech-Rod 187 is a copper-nickel electrode for shielded metal arc welding of wrought or cast alloys of similar composition as well as 80/20 and 90/10 Cu/Ni alloys. It is also used for the clad side of copper-nickel clad steels. This filler metal is widely used in marine applications because of its good resistance to the corrosive effects of sea water.

Specifications & Approvals:

AWS A5.6:2008 ECU Ni

UNS W60715

ASME QSC-395

Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	W	S	P	Ti	Al	Cu
.01	1.8	.2	.6			30.5			.004	.009	.1	.01	67

Typical Mechanical Properties

Tensile Strength	54,500 PSI	380 MPa
Yield Strength	37,500 PSI	260 MPa
Elongation	28%	

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