

INCONEL® Welding Electrode 122

INCONEL Welding Electrode 122 is used for shielded-metal-arc welding of INCONEL alloys 622 and 625, INCOLOY alloy 25-6MO, and INCOLOY alloy 825. This is an excellent dissimilar metal welding electrode that offers protection against preferential weld metal corrosion when used for joining molybdenum-containing stainless steels, INCONEL alloy C-276, and INCONEL alloy 625. It is a versatile welding product for the chemical, power, petroleum, and marine industries.

The electrodes provide excellent operability for groove and fillet welding in the downhand position and the smaller diameter electrodes are also suitable for all position welding. Power supply: direct current, electrode positive.

Specifications

AWS A5.11 ENiCrMo-10 (UNS W86022)

ASME II C SFA-5.11, ENiCrMo-10 (UNS W86022)

ASME IX, F-No.43

*(EN) ISO 14172 – ENi6022 (NiCr21Mo13W3)

*Supply to these specifications available upon request

For manufacture to ASME III (NCA3800, NB2400), and other specifications

please refer your inquiry to the Technical Department prior to order placement.

Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Limiting Chemical Composition

| | | | |
|----------|------------|--------------|-----------|
| Ni | Remainder | Cu | 0.50 max. |
| C | 0.02 max. | Co | 2.5 max. |
| Mn | 1.0 max. | Cr | 20.0-22.5 |
| Fe | 2.0-6.0 | Mo | 12.5-14.5 |
| P | 0.03 max. | V | 0.35 max. |
| S | 0.015 max. | W | 2.5-3.5 |
| Si | 0.20 max. | Others | 0.50 max. |

Minimum Mechanical Properties

| | |
|-----------------------|---------|
| Tensile Strength, psi | 100,000 |
| MPa | 690 |
| Elongation, (4d) % | 25 |

Available Product Forms – Supplied in 10lbs (4.54kg) hermetically sealed containers

| Diameter | mm in | 2.4 3/32 | 3.2 1/8 | 4.0 5/32 | 4.8 3/16 |
|---------------|----------|-------------|------------|-------------|-------------|
| Length | mm in | 229 9 | 356 14 | 356 14 | 356 14 |
| Current (DC+) | A | 50-75 | 75-100 | 80-140 | 125-150 |

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