



S. R. Industries

STAR ARC ENiCrMo-3

Type 112 (ENiCrMo-3) is an electrode which is used to weld nickel-chromium-molybdenum alloys. Its applications include dissimilar joints between nickel-chromium-molybdenum alloys to either stainless steels, carbon or low alloy steels. It is also used extensively in overlay cladding where similar chemical composition is required on the clad side. This alloy is suitable for applications where the temperature ranges from cryogenic up to 1800°F.

AWS Specification : A5.11/A5.11M:2010

AWS Classification			ENiCrMo-3				Welding Current				DCEP	
Typical Wire Chemistry												
C	Mn	Fe	P	S	Si	Cu	Nib	Co	Cr	Nb (Cb) plus Ta	Mo	other
0.10	1.0	7.0	0.03	0.02	0.75	0.50	55.0 min	D	20.0-23.0	3.15-4.15	8.0-10.0	0.50
Typical Mechanical Properties (As Welded)							Available Diameters and Operating Range in Amps					
Yield Strength, ksi			89				3/32"			65 -75		
Tensile Strength, ksi			114				1/8"			80 - 90		
Elongation%, min			34				5/32"			100 - 120		
Welding Positions			F,V,OH,H				3/16"			110 - 130		

b- includes incidental cobalt

d- is 0.12 maximum when specified by purchaser

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