



Filler Metal 112 (ENiCrMo-3)

DESCRIPTION: Filler Metal 112 welding electrodes are used for shielded-metal-arc welding of molybdenum containing stainless steels. It is also used for surfacing of steel and for welding various corrosion resistant alloys such as alloy 20. The weld metal has high strength at room and elevated temperatures and has exceptional corrosion resistance, including resistance to pitting, crevice corrosion, and polythionic acid stress-corrosion cracking. Filler Metal 112 is useful for many dissimilar joints involving stainless steels, low-alloy steels and carbon steels.

SPECIFICATION: AWS A5.11 ENiCrMo-3 (UNS W86112)
 ASME 11, Part C, SFA-5.11, ENiCrMo-3 (UNS W86112)
 ASME IX, f-No.43
 *DIN 1736 EL-NiCr20Mo9Nb (2.4621)
 *(EN) I S O 14172 - ENi6625 (NiCr22MoPNb)

*Supply to these specifications available upon request.
 For manufacture to ASME III (NCA3800, NB2400), MIL and other specifications please refer your inquiry to the Technical Department prior to order placements.

APPROVALS:
 Canadian Welding Bureau
 VdTUV 4450.00
 Other approvals may be applicable. Please confirm details of current scope of approvals with the Technical Department prior to order placement.

LIMITING CHEMICAL COMPOSITION:

Ni+Co 55.0 min.	Si 0.75 max.
C 0.10 max.	Cr 20.0-23.0
Mn 1.0 max.	Nb+Ta 3.15-4.15
Fe 7.0 max.	Mo 8.0-10.0
S 0.02 max.	P 0.03 max.
Cu 0.50 max.	Others 0.50 max.

MINIMUM MECHANICAL PROPERTIES:

Tensile Strength, psi	110,000
MPa	758
Elongation, (4d) %	30

AVAILABLE PRODUCT FORMS:

Diameter	mm	2.4	3.2	4.0	4.8
	in	3/32	1/8	5/32	3/16
Length	mm	229	356	356	356
	in	12	14	14	14
Current (DC+)	A	40-65	65-90	90-125	125-160

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

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