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ISO 9001:2008 REGISTERED
Certificate No.: 50040 & 50415

ENiCrMo10T1-1/4 DATA SHEET

Pinnacle Alloys ENiCrMo10T1-1/4
AWS CLASS ENiCrMo10T1-1, ENiCrMo10T1-4
CODE AND SPECIFICATION DATA:
AWS A5.34 ASME SFA 5.34; UNS W86022

DESCRIPTION:
Pinnacle Alloys ENiCrMo10T1-1/4 has a nominal composition (wt.-%) of 56 Ni, 22 Cr, 13 Mo, 4 Fe, 3 W. Electrodes of this classification are used for welding nickel-chromium-molybdenum alloys, for the clad side of joints in steel clad with nickel-base alloys; and for joining nickel-chromium-molybdenum alloys. Typical specifications for the nickel-chromium-molybdenum base metals are ASTM B574, B575, B619, B622, and B626, all of which have a UNS Number of N06022. Pinnacle Alloys ENiCrMo10T1-1/4 is used in offshore and marine environments, chemical and power generation equipment, and petroleum refining. It is also widely used to clad steel when exceptional corrosion resistance is required. It delivers superb performance characteristics in all positions, has little spatter, and easy-to-remove slag. Minimal weaving is required to achieve a flat, well-washed bead.

TYPE OF CURRENT: Direct Current Electrode Positive (DCEP)

DIAMETERS: .045”, 1/16”

SHIELDING GAS: 100% CO_2, 75-80% Ar/ balance CO_2, 35-50 cfh

WELDING POSITIONS: All positions

TYPICAL MECHANICAL PROPERTIES:

	AWS Spec (min)	As Welded
Ultimate Tensile Strength	100,000 psi (690 MPa)	106,000 psi (730 MPa)
Yield Strength	Not required	67,000 psi (460 MPa)
Percent Elongation in 2”	25%	38%

SOWESCO, LLC www.pinnaclealloys.com
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TYPICAL DEPOSIT COMPOSITION:

	AWS Spec	Weld Metal Analysis (%)
Carbon (C)	0.02	0.01
Chromium (Cr)	20.0-22.5	21.1
Cobalt (Co)	2.50	0.10
Copper (Cu)	0.50	0.05
Iron (Fe)	2.0-6.0	5.70
Manganese (Mn)	1.00	0.40
Molybdenum (Mo)	12.5-14.5	13.8
Nickel (Ni)	Balance	Balance
Phosphorus (P)	0.03	0.006
Silicon (Si)	0.20	0.13
Sulfur (S)	0.015	0.004
Tungsten (W)	2.5-3.5	3.23
Vanadium (V)	0.35	0.14

NOTE: Single values are maximums.

TYPICAL WELDING PARAMETERS:

Diameter	Position	Optimum			Amperage Range	Voltage Range
		Amperage	Voltage	WFS (ipm)		
.045”	Flat	180	29	400	125-200	26-32
	Out of Position	140	28	300	120-165	26-29
1/16”	Flat	250	30	300	130-300	24-32
	Out of Position	200	28	200	140-240	24-29

Note: Parameters and properties reflect CO_2 shielding gas - reduce by 2 volts when using 75-80% Ar/ balance CO_2. Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.

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 the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, “Safety in Welding and Cutting,” published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126: OSHA Safety and Health Standards 29 CRF 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

Pinnacle Alloys SDS sheets may be obtained on the website below.

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