MIDALLOY NI-MAX 122 COATED ELECTRODE

CLASSIFICATION
• AWS/SFA 5.11 Class ENiCrMo-10/ASME SFA 5.11 Class ENiCrMo-10 ASME SEC IX, F43

DESCRIPTION
• Midalloy NI-MAX 122 coated electrode is an all position coated electrode used for joining alloys listed under UNS# N06022. These include nickel-chromium-molybdenum base metals such as ASTM F574, B619, B622, and B626. Also used for overlay where a similar composition is required on the clad side.
• UNS# W86022
• ISO 14172 comparison classification ENi6022
• These electrodes can also be used in dissimilar applications involving nickel-chromium-molybdenum alloys welded to stainless steels containing molybdenum.

APPLICATION
• NI-MAX 122 is used for a wide range of applications in the chemical, power, petroleum, and marine industries.
• NI-MAX 122 offers excellent corrosion resistance in both oxidizing and reducing media used for chemical processing.
• NI-MAX 122 offers an outstanding resistance to stress corrosion cracking, pitting, and crevice corrosion.

TYPICAL CHEMISTRY

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Cr	Mo	V	W
.015	.33	2.7	.010	.006	.15	.05	57.75	.01	21.29	14.0	.01	3.24

TYPICAL WELDING PROPERTIES

TENSILE STRENGTH	114,000 PSI
YIELD STRENGTH	79,000 PSI
ELONGATION IN 2"	36%

RECOMMENDED WELDING PARAMETERS

DIAMETER	3/32"	1/8"	5/32"	3/16"
PROCESS	SMAW	SMAW	SMAW	SMAW
VOLTAGE	24-28	26-30	28-32	28-32
AMPERAGE FLAT	70-85	65-100	110-140	120-160
AMPERAGE VERTICAL/OVERHEAD	65-75	65-90	100-120	110-130

STANDARD PACKAGING
• 3/32" – 8 lb. can, 48 lb. carton
• 1/8", 5/32", 3/16" – 10 lb. can, 60 lb. carton

3-9-11

Midalloy