

<b>International standards</b>	Material No.	
	DIN 1736	
	AWS A5.11	E NiCrMo-10

**Typical applications and characteristics**

CARBOWELD 122 is a basic coated core wire alloyed nickel base electrode.

Suitable for welding of NiCrMo-alloys and for overlay claddings on carbon steels, low alloy steels or stainless steels where similar alloy is required.

Also used for dissimilar joining among NiCrMo, stainless steel, Carbon steel and low alloy steels.

The deposits offers an excellent resistance to corrosion and to both oxidizing and reducing media, as well at low as at high temperatures.

**Mechanical properties of all-weld metal**

( typical values)

Tensile strength $R_m$ N/mm <sup>2</sup>	Yield strength $R_{p0,2}$ N/mm <sup>2</sup>	Elongation $A_5$ %
780	520	47

**Weld metal analysis**  
(typical, wt. %)

C	Mn	Si	Cr	Mo	Fe	W	Ni
0,02	<1	<0,2	20-22,5	12,5-14,5	2-6	2,5-3,5	Bal.

**Current**

= +

**Welding positions**

PA, PB, PC, PD, PE, PF

**Rebaking**

1 h, 350 °C + / - 10 °C ( if required )

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 300	55- 75					
3,2 x 350	80-100					
4,0 x 350	125-150					

Rev. 000