

Wire and Welding products

HAYNES
Wire Company



HAYNES® 112 Coated Electrodes

Product Description:

HAYNES® 112 coated electrodes are used for shielded metal arc welding of 625, 825 and molybdenum-containing alloys. The weld metal has good resistance to corrosion including pitting and crevice corrosion. In addition, the electrodes are useful for overlay and cladding of various grades of steel including stainless, low alloy and carbon steels. The electrode makes a great dissimilar joining electrode when joining HAYNES® and HASTELLOY® materials to stainless and carbon steels. The coating is designed for great operability, especially out-of-position welding.

Specifications:

AWS A5.11 ENiCrMo-3
ASME SFA-5.11 ENiCrMo-3

ASME IX F-43
UNS W86112

Weld Deposit Chemistry:

Ni.....55 min.
Cr.....20.0 - 23.0
Co.....0.12 max.*
Mo.....8.0 - 10.0
Fe.....7.0 max.
Mn.....1.0 max.
Nb + Ta.....3.15 - 4.15

Si.....0.75 max.
Cu.....0.5 max.
Other.....0.5 max.
C.....0.1 max.
P.....0.03 max.
S.....0.02 max.

*When specified by customer

Minimum Mechanical Properties:

Tensile (psi) 110,000
Mpa 759
Elongation (%) 30

Available Product Forms:

Diameter (in)	.093 (3/32)	.125 (1/8)	.156 (5/32)	.187 (3/16)
Length (in)	10	14	14	14
Pkg Wt (lbs)	5	10	10	10
Current (A) DCEP	40-70	70-100	80-140	120-150

Packaged in Hermetically Sealed Containers

HW-7004

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