

# Wire and Welding products

**HAYNES**  
Wire Company



## HAYNES® 122 Coated Electrodes

### Product Description:

HAYNES® 122 coated electrodes are used for the shielded metal arc welding of alloys C-22, 622, 625 and 825. The electrodes are also a good candidate for welding stainless steels that contain molybdenum for corrosion resistance. The alloy also effectively overmatches alloys 625 and C-276. The electrodes have a slag system that promotes great operability in all positions, especially out-of-position welding.

### Specifications:

AWS A5.11 ENiCrMo-10  
ASME-SFA-5.11 ENiCrMo-10  
Kennblatt 04534.03\*

UNS W86022  
ASME IX F-43

\*Specify at time of order

### Weld Deposit Chemistry:

Ni.....Balance  
Cr.....20.0—22.5  
Co.....2.5 max.  
Mo.....12.5 - 14.5  
Fe.....2.0 - 6.0  
Mn.....1.0 max.  
V.....0.35 max.

Si.....0.2 max.  
Cu.....0.5 max.  
Other.....0.5 max.  
C.....0.02 max.  
P.....0.03 max.  
S.....0.015 max.  
W.....2.5 - 3.5

### Minimum Mechanical Properties:

Tensile (psi)           100,000  
Mpa                       690  
Elongation (%)           25

### 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-7006

**HAYNES**  
Wire Company

158 N. Egerton Road P.O. Box 677 Mountain Home, North Carolina USA 28758-0677  
Telephone: 828-692-5791 800-438-7263 FAX: 828-697-9818 haynesintl.com

HAYNES® 122 Coated Electrodes