



Manufacturers of Custom Welding Lines for Resale  
www.selectrode.com

## SELECTRODE

# 1112

All Position 625 Inconel  
Electrode

### INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.11 E NiCrMo3

EN ISO 14172

DIN 1736: EL NiCr20Mo9Nb

ENi6625 NiCr22Mo9Nb

### FEATURES & APPLICATIONS

- Phenomenal strength and crack resistance
- Excellent positional performance
- Weld metal is highly corrosion resistant
- Used extensively in the petrochemical industries

### ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

**Flux Color:** Grey

C	Mn	Fe	P	S	Si	Cu	Cr	Nb	Mo	Ni
.09	.8	6.7	.03	.02	.70	.50	22	4.0	9.5	Bal.

### TYPICAL MECHANICAL PROPERTIES

#### Undiluted Weld Metal

Tensile Strength

Yield Strength

Elongation

#### Maximum Value Up to:

116,000 PSI (800 MPa)

70,000 PSI (480 MPa)

46 %

### WELDING CURRENT & INSTRUCTIONS

**Recommended Current:** DC Reverse (+)

Diameter (mm)	3/32 (2.4)	1/8 (3.2)	5/32 (4.0)
Minimum Amperage	60	90	120
Maximum Amperage	85	120	155

**Welding Techniques:** Use the lowest possible amperage and weld with a stringer bead technique

**Welding Positions:** Flat, Horizontal, Vertical up, Overhead

**Deposition Rates:**

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings
3/32 (2.4)	10" (250)	.35 oz (10g)	42 (92)	45 (100)	65
1/8 (3.2)	14" (350)	.76 oz (21g)	23 (51)	22 (49)	90
5/32 (4.0)	14" (350)	106 oz (31g)	17 (37)	20 (45)	105

**APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS**

	3/32 (2.4)	1/8 (3.2)	5/32 (4.0)
Length (mm)	10" (250)	14" (350)	14" (350)
Electrodes / lb	24	13	9
Electrodes / kg	53	29	20