

TECH-ROD 134

I. **DESCRIPTION:** Tech-Rod 134 electrodes are used for welding of NiCrFe Alloys as well as low alloy steels such as 9% nickel steels and 5% nickel steels for cryogenic service up to 196°C. This is an A.C/D.C. electrode specially designed for A.C. welding without any arc blow when welding low alloy steels.

II. **APPROVALS:** Manufactured under Quality System approved by ASME & ISO9001. Meets AWS A5.11, Class ENiCrFe-4.

III. **CHEMICAL COMPOSITION**

Carbon	0.06
Manganese	2.10
Silicon	0.35
Iron	9.5
Chromium	15.50
Molybdenum	3.1
Columbium	2.4
Phosphorus	.010
Sulfur	0.009
Nickel	Balance

MECHANICAL PROPERTIES

Tensile Strength	
100,500 PSI	690 MPA
Yield Strength	
63,800 PSI	440 MPA
Elongation	
Impact @ -196°C	31% 40 ft/lbs 54 Joules

IV. **WELDING PARAMETERS**

Direct Current
Electrode + Ve

Alternate Current

AMPERAGES:

3/32"	65-75
1/8"	90-105
5/32"	120-135
3/16"	135-155

(For vertical welding amperages are to be reduced by 10 to 15 amps)

V. **PACKAGES AVAILABLE:**

3/16"-10# can, 5/32"-10# can, 1/8"-10# Can, 3/32"-8# can

