

TECH-ROD 620

- I. **DESCRIPTION:** Tech-Rod 620 electrodes are used for welding of NiCrMo Alloys as well as low alloy steels such as 9% nickel steels and 5% nickel steels. They can be used for cryogenic service conditions up to -196°C. This is an A.C/D.C. electrode specially designed for A.C. welding and it will not create arc blow conditions when welding low alloy steels.
- II. **APPROVALS:** Manufactured under Quality System approved by ASME & ISO9001. Meets AWS A5.11, Class ENiCrMo-6.

III. **CHEMICAL COMPOSITION**

Carbon	0.06
Manganese	3.1
Silicon	0.33
Iron	9.2
Chromium	14.7
Molybdenum	6.4
Columbium	1.05
Tungsten	1.75
Phosphorus	0.009
Sulfur	0.008
Nickel	Balance

MECHANICAL PROPERTIES

Tensile Strength	
101,200 PSI	700 MPA
Yield Strength	
64,200 PSI	440 MPA
Elongation	
	30%
Impact @ -196°C	38 ft/lbs 51 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

