



# Tech-Rod 135

**Description:** Tech-Rod 135 is a covered electrode which is used for welding of nickel-iron-molybdenum-copper alloys. This electrode can be used to weld dissimilar joints between nickel alloys and stainless steels or low alloy steels as well as for overlay cladding where similar chemical composition is required.

## Specifications & Approvals:

**AWS**

**UNS**

**ASME QSC-395**

## Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	W	S	P	Ti	Al	Cu
.02	2.1	.40	27.4	29.3	3.20	35.2			.005	.009			1.8

## Typical Mechanical Properties

Tensile Strength	PSI	MPa
Yield Strength	PSI	MPa
Elongation	%	

## Welding Parameters

Process	Diameter x Length	Voltage	Amperage	
			Flat	Vertical & Overhead
SMAW	3/32" (2.4mm) x 12" (305mm)	24-28	70-85	65-75
	1/8" (3.2mm) x 14" (355mm)	26-30	85-110	80-90
	5/32" (4.0mm) x 14" (355mm)	28-32	110-140	100-120
	3/16" (4.8mm) x 14" (355mm)	28-32	120-160	110-130

## Standard Packages:

3/32" Diameter	8 Lb (3.6Kg) Can	24 Lb (10.9Kg) Master Carton	26 Electrodes per Lb
1/8" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	14 Electrodes per Lb
5/32" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	9 Electrodes per Lb
3/16" Diameter	10 Lb (4.5Kg) Can	30 Lb (13.6Kg) Master Carton	6 Electrodes per Lb