



NICKEL A Welding Electrodes

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



American Welding Society
Sustaining Company Member



ALLOY DESCRIPTION AND APPLICATION;

Washington Alloy "A" is a nickel-chromium-iron flux-coated electrode designed primarily for shielded metal arc welding of Incoloy® 800 to itself or to 9% nickel steels. This electrode is used for welding a variety of dissimilar wrought or cast forms of carbon steel, austenitic and ferritic stainless steel, and nickel-chromium Inconel® 600 to themselves or to each other. Washington Alloy "A" is frequently used for joining Incoloy® 800 to high nickel alloys 200 and 201 or to nickel-copper Monel® 400 and K-500. Washington Alloy "A" is excellent for overlaying nickel-chromium alloy on steel. More common applications include the welding of 5% and 9% nickel steel transport or storage tanks used for cryogenic products. The chemical or petrochemical industries use Washington Alloy "A" for many applications such as valve seats and gates, coal gasification and wet process desulphurization equipment.

TYPICAL WELDING PROCEDURES; DCEP(DC+)

Diameter	Amps (Flat)	Diameter	Amps (Flat)
3/32"	60-100	1/8"	90-150
5/32"	130-200	3/16"	200-240

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

TYPICAL WELD METAL CHEMISTRY (%) & PROPERTIES (AWS Chemistry & typical mechanical)

	AWS Spec.		AWS Spec.
Carbon	0.10 max	Nickel	62.0 min.
Iron	12.0 max	Cobalt	0.12 max when specified
Niobium (Nb) or Cb + Ta	0.5-3.0	Chromium	13.0-17.0
Copper	0.50 max	Molybdenum	0.5-2.50
Manganese	1.0-3.5		
Silicon	0.75 max	Tensile Strength (psi)	80,000 min
Sulphur	0.02 max	Elongation in 2"(%)	30% min
Phosphorus	0.03 max		

AVAILABLE SIZES: TN NI-A 3/32, 1/8, 5/32, 3/16

Other sizes available – please inquire

SPECIFICATIONS; AWS A5.11 ENiCrFe-2
ASME SFA 5.11 ENiCrFe-2

EAST COAST
7010-G Reames Rd
Charlotte, NC 28216
Tel (888) 522-8296
Fax (704)598-6673

GULF COAST
4755 Alpine Drive #100A
Stafford, TX 77477
Tel (877) 711-9274
Fax (281)313-6332

WEST COAST
8535 Utica Ave
Rancho Cucamonga, CA 91730
Tel(800)830-9033
Fax (909)291-4586



DC 2012

Warehouse Distribution Center – Dayton, Ohio

Head Office – Puyallup, Washington

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