



Supplier of Welding Alloys

## Nickel Alloy Coated Electrodes

### Oxford Alloy® 122

**SPECIFICATIONS**

AWS 5.11  
ASME SFA 5.11

**CLASSIFICATIONS**

AWS ENiCrMo-10  
UNS W86022

**DESCRIPTION / APPLICATION**

Oxford Alloy 122 is a solid solution, nickel-chromium-molybdenum, corrosion resistant alloy that has exceptional versatility. This electrode is used for welding of nickel-chromium-molybdenum alloys as well as for overlay cladding on carbon, low-alloy, or stainless steels. These electrodes are also used for dissimilar joints between nickel-chromium-molybdenum alloys and stainless, carbon, or low alloy steels. Typical specifications for the nickel-chromium-molybdenum base metals are ASTM, F574, B619, B622, and B626 all of which have UNS Number N06022. Oxford Alloy 122 offers excellent corrosion resistance in oxidizing as well as reducing media in a wide variety of chemical process environments. This electrode also offers an outstanding resistance to stress corrosion cracking, pitting, and crevice corrosion.

AWS Chemical Composition						
C	Mn	Si	Cr	Mo	W	S
0.02 max	1.0 max	0.2 max	20.0-22.5	12.5-14.5	2.5-3.5	0.015 max
P	Ni	Fe	Cu	Co	V	OET
0.03 max	Bal	2.0-6.0	0.50 max	2.5 max	0.35 max	0.50 max

**TYPICAL MECHANICAL PROPERTIES**

Tensile strength: 114,000 psi 790 Mpa

Yield strength: 78,500 psi 540 MPa

Elongation: 36%

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.

Data contained in this publication are typical of the products and properties described, but are not suitable for specifications.  
OXFORD ALLOYS is a registered trademark of Oxford Alloys, Inc.