



Supplier of Welding Alloys

Nickel Alloy Coated Electrodes

Oxford Alloy® A

SPECIFICATIONS

AWS 5.11
ASME SFA 5.11

CLASSIFICATIONS

AWS ENiCrFe-2
UNS W86133

DESCRIPTION / APPLICATION

Oxford Alloy A electrodes are used for shielded-metal-arc welding of Incoloy® alloys 800 and 800HT, Inconel® alloys 600 and 601, and nickel steels. The weld metal of this electrode has excellent strength and oxidation resistance at high temperatures and retains impact resistance at cryogenic temperatures. Oxford Alloy A is an exceptional versatile product. This electrode can be used on a variety of austenitic and ferritic steels and nickel alloys. Some examples are combinations of stainless steels, carbon steels, Inconel® alloys, Incoloy® alloys, Monel® alloys, and copper-nickel alloys. Oxford Alloy A is especially useful for general maintenance welding of equipment exposed to strenuous service conditions. This electrode can be operated in all welding positions. The power supply is direct current, electrode positive.

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| AWS Chemical Composition | | | | | | |
|--------------------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Ni | C | Mn | Fe | S | Si | Cu |
| 62.0 min | 0.10 max | 1.0- 3.5 | 12.0 max | 0.02 max | 0.75 max | 0.50 max |
| Cr | Cb+Ta | Mo | P | OET | | |
| 13.0- 17.0 | 0.5- 3.0 | 0.5- 2.5 | 0.03 max | 0.50 max | | |

TYPICAL MECHANICAL PROPERTIES

Tensile strength: 89,000 psi 610 MPa
Yield strength: 72,000 psi 500 MPa
Elongation: 36%

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

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