

TECH-ROD® 187

Nickel ▪ AWS ECuNi

KEY FEATURES

- A copper-nickel electrode for welding alloys of similar composition as well as 80/20 and 90/10 Cu/Ni alloys
- Q2 Lot® - certificates showing actual deposit composition available online

CONFORMANCES

AWS A5.6/A5.6M: 2008	ECuNi
ASME SFA-A5.11	ECuNi
UNS	W60715

TYPICAL APPLICATIONS

- Marine applications
- Good resistance to the corrosive effects of sea water
- Used for the clad side of copper-nickel clad steels

DIAMETERS / PACKAGING

Diameter in (mm)	Length in (mm)	8 lb (3.6 kg) Can 24 lb (10.9 kg) Master Carton	10 lb (4.5 kg) Can 30 lb (13.6 kg) Master Can
3/32 (2.4)	12 (305)	EL187093632	EL187125634
1/8 (3.2)	14 (355)		

MECHANICAL PROPERTIES - As Required per AWS A5.6/A5.6M: 2008

	Tensile Strength Mpa (ksi)	Elongation %
Requirements AWS A5.11/A5.11M:2010	345 (50 min)	20 min
Typical Performance Tech-Rod® 187	360 (52)	24

DEPOSIT COMPOSITION⁽¹⁾ - As Required per AWS A5.6: 2008

	%Mn	%Fe	%P	%Si	%Cu
Requirements AWS ECuNi	1.00 - 2.50	0.40 - 0.75	0.020 max	0.50 max	Remainder
Typical Performance⁽²⁾ Tech-Rod® 187	1.58	0.60	0.001	0.01	63.0
	%Ni	%Ti	%Pb	%Other	
Requirements AWS ECuNi	29.0 - 33.0	0.50 max	0.02 max	0.50 max	
Typical Performance⁽²⁾ Tech-Rod® 187	30.4	0.24	0.001	<0.50	

TYPICAL OPERATING PROCEDURES

Diameter in (mm)	Length in (mm)	Flat	Amperage	Vertical & Overhead
3/32 (2.4)	12 (305)	70-85	85-110	65-75
1/8 (3.2)	14 (355)	85-110		80-90

⁽¹⁾Typical all wire chemistry. ⁽²⁾See test results disclaimer on pg. 13.
Safety Data Sheets (SDS) are available on our website at www.lincolnelectric.com

Material Safety Data Sheets (MSDS) and Certificates of Conformance are available on our website at www.lincolnelectric.com

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

CUSTOMER ASSISTANCE POLICY

The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for information or advice about their use of our products. Our employees respond to inquiries to the best of their ability based on information provided to them by the customers and the knowledge they may have concerning the application. Our employees, however, are not in a position to verify the information provided or to evaluate the engineering requirements for the particular weldment. Accordingly, Lincoln Electric does not warrant or guarantee or assume any liability with respect to such information or advice. Moreover, the provision of such information or advice does not create, expand, or alter any warranty on our products. Any express or implied warranty that might arise from the information or advice, including any implied warranty of merchantability or any warranty of fitness for any customers' particular purpose is specifically disclaimed.

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Subject to Change – This information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.com for any updated information.

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