



HI-ALLOY 122

BRONZE ELECTRODE

DESCRIPTION: Hi-Alloy 122 is an all position electrode used extensively for the welding of copper, brass, bronze, cast iron, steel, and for joining dissimilar combinations of these metals. It is excellent for overlay and build-up where resistance to corrosion by sea water or chemical solutions is required. 122 is alloyed with nickel so its deposits are harder and more wear resistant than other bronze electrodes, yet remain machinable.

TYPICAL APPLICATIONS: Repair and resurfacing of gear wheels, impellers, bearings, turbines, valve bodies, and defects in castings.

PROCEDURES: The edges of heavy material should be beveled to form a 45° vee. Preheat is not required but is always desirable. Normal arc length should produce a good solid weld. Slag is removed easily after the bead is allowed to cool slightly.

AVAILABLE SIZES:	3/32	1/8	5/32
AMPERAGE RANGES:	80-120	110 - 160	120 - 200
POLARITY:	DC Reverse		
TENSILE STRENGTH:	Up to 60,000 psi		
HARDNESS:	Up to 120 Brinell		