

# Inweld NA-112

AWS A5.11 ENiCrMo-3

## Chemical Composition of Inweld NA-112

Fe	C	Cr	Ni	Nb & Ta	Mn	Si	P	S	Cu	Mo	Other
7.0	0.10	20.0- 23.0	55.0 Min	3.15- 4.15	1.0	0.75	0.03	0.02	0.5	8.0- 10.0	0.50

Single values are maximum unless otherwise specified.

## Description and Applications

For arc welding Incoloy® 800 and 801, Inconel® 601 and 625, for overlaying carbon steel and for joining 9% nickel steel. NA-112 is also use for many dissimilar welding combinations of steel or stainless steel to nickel-iron-chromium alloys. The following is a list of possible combinations: Incoloy® 825 to stainless steels, low alloy steels, and carbon steels; Incoloy® 800 to 825; Inconel® 625, 706, 718, and X-750 to 9% nickel steels; Inconel® 625, Monel® K-500, Incoloy® 800 and 825 to Inconel® 706, 718, and X-750. Commonly used for pressure vessel super-heaters, steam separators and tube plates. Cryogenic installations, chemical and petrochemical applications, for heat-treatment and case hardening industrial furnace parts. Avg. Charpy V-notch impact value is 41 ft-lbs @ -300°F.

## Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	110,000 psi
Yield Strength:	70,000 psi
Elongation:	35%

## Recommended Parameters

Wire Diameter      Voltage      Amperage      Wire Feed IPM

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