



FCW NI82

Classification

AWS A5.34 : ~ENiCr3T0-4

Material N° : 2.4648

ISO 12153 : T Ni 6083 (NiCr20Mn6Fe4Nb) B M21 3

Description & Applications

Flux cored nickel base wire for gas shielded arc welding in flat position of high nickel alloys such as Inconel 600, 800. Used for special austenitic stainless steels or dissimilar joining (Low alloy/ Stainless steel, Stainless Steel / Nickel Base). Good resistance to various types of corrosions.

Main applications: Cladding ion steels of 5% and 9% Ni. Equipment subject to acid very high temperature, repair of difficult to weld steels, buffer layer

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	Fe	Nb	P	S	Ni
0.02	0.2	5.50	20.0	1.30	2.40	2.40	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
400	650	40	20°C	180
			-196°C	80

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Stick out (mm)	Shielding Gas
		Pulsed arc (A)	(V)		
= +	1.2	130 – 250	24 – 32	12 – 25	ISO 14175 : M21 18-20 l/min



FT-En-C069A-1409

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr