



A₅ 'NI82

Classification

ISO 18274 : S-Ni 6082 (NiCr20Mn3Nb)
 AWS A5.14 : ERNiCr-3

Material N° : 2.4806

Description & Applications

Solid wire for GMAW of high nickel content alloys as Inconel 600* or Incoloy 800*. Highly resistant at low temperatures on steels of 5% and 9% Ni. Used in the construction of equipment submitted to oxidizing and corrosive attacks at high temperatures.

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Typical Chemical Composition (%)

C	Si	Mn	Cr	Fe	Nb	Ti	P	S	Ni
0.02	0.2	3.0	20.5	2.0	2.5	0.3	<0.02	<0.01	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
410	650	45	+20°C	200
			-196°C	80

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG = +	0.8	80-140	23-27	Ar Ar + He Ar/He + 0.05% CO ₂ 18-20 l/min
	1.0	90-160	24-28	
	1.2	160-200	24-28	
	1.6	180-260	24-28	

Ind.10



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