Selectarc WELDING

SELECTARC UP Ni82

Solid Wire for SAW

Classification

AWS A5.14 : ERNiCr3 Material N° : 2.4806
ISO 18274 : S-NiCr20Mn3Nb

Characteristics

Solid high Nickel alloyed wire electrode for submerged arc welding (SAW) . Used for cladding of low alloyed and alloyed steels, for welding iron- and nickel base alloys and for dissimilar joints. Used for low temperature alloys as well as for high temperature Nickel alloys, for service temperatures from –196°C up to 900°C.

Applications

Construction welding of Ni- steels, corrosion resistant steels, high temperature and nickel alloys in component manufacturing and furnace construction.

Base Materials

UNS	Alloy	DIN	Material N°
K81340	9%Ni	X8Ni9	1.5662
N06600	600	NiCr15Fe	2.4816
N06601	601	NiCr23Fe	2.4851
N08800	800	X10NiCrAlTi3220	1.4876
N08810	800H	X5NiCrAlTi3120	1.4958
	DS	X8NiCrSi3818	1.4862

Typical Wire Composition (%)

C	Si	Mn	Cr	Fe	Nb	Ti	P	S	Ni
0.020	0.20	3.00	20.50	2.00	2.50	0.30	0.010	0.006	base

All Weld Metal Mechanical Properties (Typical)

Conditions	UTS	YS	% Elg	Impact (KV)	
	Rm (MPa)	Rp0.2 (MPa)	A_5	Temp.°C	J
AW	670	430	40	+ 20	100
				- 196	60

Welding Current & Instructions

Process	Ø (mm)	Welding Parameters				Flux
		Current (A)	Voltage (V)	Speed cm/mim	Stick out (mm)	
SAW = +	1.60	200 - 250	27 - 30	45 - 60	~ 13	UP Ni02
	2.00	220 - 330	27 - 30	45 - 60	~ 16	
	2.40	300 - 360	27 - 30	50 - 70	~ 19	

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