TIG NI82

Old reference: TIG Ni82

Classification

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

Description & Applications

Solid rod for TIG welding of high nickel content alloys like Inconel 600* or Incoloy 800*. High resistance 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.

* Trade mark INCO ALLOYS

Typical Chemical Composition (%)

C	Si	Mn	Cr	Fe	Nb	Ti	P	S	Ni
0.03	0.2	3.2	20.5	2.0	2.3	0.3	<0.01	<0.01	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
430	670	42	+20°C 160 -196°C 100

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min Back shielding : Argon : 3-6 l/min

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