Standards

TS EN ISO 14172	: E Ni 6082 (NiCr20Mn3Nb)
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AWS A5.11	: ~ E NiCrFe 3

Chemical Composition of Weld Metal % (Typical)

C	Mn	Si	Mo	Ni	Fe	Cr	Ti	Nb
0.05	4.5	0.4	1.5	>65	3.0	20.0	0.25	1.8

Mechanical Properties

Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/+20°C)	Elongation ($L_0=5d_0$) (%))
min. 390	630 - 710	min. 60 J	min. 30

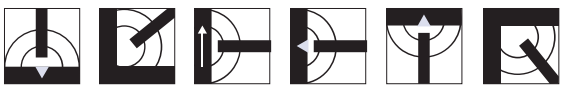
Typical Base Material Grades

- Un-alloyed and alloyed, high temperature steels to X8Ni9, high alloyed Cr and CrNi Steels, particularly for mixed alloy joints. Nickel and nickel alloys and joints to steels.
- NiCr 15 Fe, LC-NiCr 15Fe, NiCr 60 15, INCONEL 600 / 600 L, INCOLOY 800

Features and Applications

- Resisting to low and high temperature and creep, low and unalloyed steels contain up to % 9 Ni Ni and Ni Alloys and pressure vessels
- Weld metal has non-scalling structure at -196°C and 1200°C
- Weld metal is stainless, austenitic steels and resistance to thermal shock

Welding Positions



Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010102016	2.50 x 250	3/32 x 10”	50-80	1750
3010102021	3.20 x 300	1/8 x 12”	75-105	3350
3010102026	4.00 x 350	5/32 x 14”	90-130	5490

Approvals: SEPRO, ABS