

Standards

TS EN ISO 18274	: S Ni 6082
EN ISO 18274	: S Ni 6082
AWS A5.14	: ER NiCr-3

**Chemical Composition of
Welding Wire % (Typical)**

Ni	C	Cr	Mn	Fe	Nb
Rest	0.02	20.0	3.0	4.0	2.5

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/+20°C)	Elongation ((L ₀ =5d ₀) (%))
400	650	150 J	40

Typical Base Material Grades

- 2.4816 - 2.4817 - 2.4806 - Alloy 600 - 1.4876 - 1.5662 - 1.5680, 2.4951, 2.4961, 1.4981, 1.4985

Features and Applications

- Especially in welding of Nickel based alloys high temperature and creep resistant steels, problematic steels and dissimilar joints
- Weld metal mechanical properties are resistant to heat treating
- Shielding gas: Ar (MIG and TIG)

Welding Positions

Welding Electrode

GeKaTec ANTI-CRACK 7015

Current Type

MIG D.C. (+) / TIG D.C.(-)

Operating Data

Product Code	Diameter x Length (mm) / (inch)	Package Weight (Kg)
6031100301	1.00 / 0,040"	15
6031100302	1.20 / 0,047"	15
6031100106	1.6 x 1000 / 1/16 x 39"	5
6031100107	2.0 x 1000 / 5/64 x 39"	5
6031100303	2.4 x 1000 / 3/32 x 39"	5

Approvals: SEPRO