

KW-A82

For nickel alloy (Inconel 600, 601)

Classifications

EN ISO 14172:2004	: E Ni 6182
AWS A5.11-05	: ENiCrFe-3
JIS Z 3224	: DNiCrFe-3
KS D 7021	: DNiCrFe-3

Description

- Covering is low hydrogen type for welding of Ni-Cr-Fe alloy steel (Inconel 600,601) or different materials such as Inconels, Inconel and low alloy steels, stainless steels and low alloy steels.
- KNCF-A82 makes safety welding with good weldability and usability.
- Excellent heat resistance, corrosion resistance and mechanical quality of all weld metal.
- Redry the electrode at 300 - 400 °C for 1 – 2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Fe	Ni	Cr	Ti	Nb + Ta
0.02	0.57	5.57	0.010	0.004	7.32	Rem.	15.27	0.12	2.16

Typical mechanical properties of all-weld metal

	Yield Strength (0.2%OS)	Tensile Strength	Elongation	Remarks
	(MPa)	(MPa)	(%)	
AWS A5.11		Min. 550	Min. 30	
EN ISO 14172	Min. 360	Min. 550	Min. 27	
Example	510	660	48	AW

*AW: As-welded

Sizes available and recommended currents (DC +)

Diameter	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	300	350	350
Amperage	F	60-80	80-120	120-150	150-180
	V . OH	50-70	70-100	100-140	-