

KW-A82M

For nickel alloy

Classifications

EN ISO 14172:2004	: E Ni 6082
AWS A5.11-05	: ENiCrFe-3 (mod)

Description

- Covering is low hydrogen type for welding of Ni-Cr-Fe alloy steel or different materials such as Inconels, Inconel and low alloy steels, stainless steels and low alloy steels
- 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	Mo	Nb + Ta
0.04	0.34	4.24	0.003	0.010	2.96	Rem.	20.20	1.73	1.95

Typical mechanical properties of all-weld metal

	Yield Strength (0.2%OS)	Tensile Strength	Elongation	Remarks
	(MPa)	(MPa)	(%)	
EN ISO 14172	Min. 360	Min. 600	Min. 22	
Example	430	690	47	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
(A)	V . OH	50-70	70-100	100-140	-