

KW-T82

For Inconel 600,601,690 / Incoloy 800, 800HT

Classifications

EN ISO 18274:2005	: SNI6082 (NiCr20Mn3Nb)
AWS A5.14-2011	: ERNiCr-3
KS B 18274:2014	: SNI6082 (NiCr20Mn3Nb)
JIS Z 3334:2011	: SNI6082 (NiCr20Mn3Nb)

Approvals – I1 (100% Ar)

ABS	: ERNiCr-3
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Description

- TIG consumable for Inconel 600, Incoloy 800(HT) (ASTM B 163, B166, B167 or UNS NO6082)
- It can be used for dissimilar welding Inconel 600 with steels or stainless steels
- The weld metal has high strength and good corrosion resistance at elevated temperature

Polarity & shielding gas

- DCEN (DC-)
- Ar: 100% Ar (15 – 25 l/min)

Typical chemical composition of all-weld metal (%)

C	Si	Mn	Ni	Cr	Fe	Nb + Ta
0.02	0.11	3.09	71.9	20.32	1.04	2.44

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)	
	(MPa)	(MPa)	(%)	-20 °C	-50 °C
AWS A5.9		Min. 760	Min. 15		
Example	640	800	32	220	200

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation
	(MPa)	(MPa)	(%)
AWS A5.14		Min. 550	
Example		640	36