FLUX CORED 82-T1

Specifications: A5.34: 2007

Classification: AWS: ENiCr3T1-1/-4

Description:

FLUX CORED 82-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO2 or Argon/CO2 mixtures. The wire possesses excellent weldability and can be used in a wide variety of similar and dissimilar welding and cladding applications. Some typical applications include joining Ni-Cr-Fe alloys, surfacing steel with Ni-Cr-Fe weld metal, or joining Inconel® 600, 601 and Incoloy® 800 to themselves or to stainless and carbon steels.

Typical Deposit Chemistry

C	Mn	Fe	P	S	Si
0.10 max	2.5 - 3.5	3.0 max	0.03 max	0.015 max	0.50 max
Cu	Ni	Co	Cr	Nb(Cb) + Ta	
0.50 max	67 min		18.0-22.0	2.0-3.0	
Mo	V	W	Other	Ti	
			0.50 max	0.75 max	

Typical Mechanical Properties

Tensile Strength	89,000 psi
Yield Strength	58,000 psi
Elongation % in 2"	26 %

FLUX CORED 622-T1

Specifications: A5.34: 2007

Classification: AWS: ENiCrMo10T1-1/-4

Description:

FLUX CORED 622-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO2 or Argon/CO2 mixtures. The wire possesses excellent weldability and is used in welding Ni-Cr-Mo alloys. Typical specifications for the Ni-Cr-Mo base metals are ASTM B574, B575, B619, B622, and B626, all of which have UNS# N06022.

Typical Deposit Chemistry

C	Mn	Fe	P	S	Si
0.02 max	1.0 max	2.0 - 6.0	0.03 max	0.015 max	0.2 max
Cu	Ni	Co	Cr	Mo	V
0.50 max	Rem	2.5 max	20.0 - 22.5	12.5 - 14.5	0.35 max
W	Other				
2.5 - 3.5	0.50 max				

Typical Mechanical Properties

Tensile Strength	115,000 psi
Yield Strength	82,000 psi
Elongation % in 2"	34 %

FLUX CORED 625-T1

Specifications: A5.34: 2007

Classification: AWS: ENiCrMo3T1-1/-4

Description:

FLUX CORED 625-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO2 or Ar/CO2 mixtures. The wire possesses excellent weldability and can be used in a wide variety of similar and dissimilar welding and cladding applications. Some typical applications include joining Ni-Cr-Mo alloys, surfacing steel with Ni-Cr-Mo weld metal, joining steels to nickel based alloys, and joining 9% nickel steel for cryogenic applications.

Typical Chemistry Analysis

C	Mn	Fe	P	S	Si
0.10 max	0.50 max	5.0 max	0.02 max	0.015 max	0.50 max
Cu	Ni	Co	Cr	Nb(Cb) + Ta	
0.50 max	58 min		20.0 - 23.0	3.15 - 4.15	
Mo	V	W	Other	Ti	
8.0 - 10.0			0.50 max	0.40 max	

Typical Mechanical Properties

Tensile Strength	112,000 psi
Yield Strength	72,000 psi
Elongation % in 2"	38 %

FLUX CORED C276-T1

Specifications: A5.34: 2007

Classification: AWS: ENiCrMo4T1-1/-4

Description:

FLUX CORED C276-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO2 or Argon/CO2 mixtures. The wire possesses excellent weldability and is used in welding Low Carbon Ni-Cr-Mo alloys to other nickel base alloys. Typical specifications for the Ni-Cr-Mo base metals are ASTM B574, B575, B619, B622, and B626, all of which have UNS# N10276.

Typical Chemistry Analysis

C	Mn	Fe	P	S	Si
0.02 max	1.0 max	4.0 - 7.0	0.03 max	0.03 max	0.2 max
Cu	Ni	Co	Cr	Mo	V
0.50 max	Rem	2.5 max	14.5 - 16.5	15.0 - 17.0	.035 max
W	Other				
3.0 - 4.5	0.05 max				

Typical Mechanical Properties	
Tensile Strength	110,000 psi
Yield Strength	75,000 psi
Elongation % in 2"	37 %

Please note that not all of the Nickel Flux Cored Wires are listed in this catalog. If you can not find what you are looking for, please contact WeldCor in BC at 1-604-701-6533 or in Alberta at 1-780-468-1777.