



FILLER METAL 182 (ENiCrFe-3)

DESCRIPTION: Filler Metal 182 is used for shielded-metal-arc welding of Alloys 600 and 601. The weld metal has excellent high-temperature strength and oxidation resistance and can meet stringent radiographic requirements. The electrodes provide excellent operability for groove and fillet welding in the downhand position and the smaller diameter electrodes are also suitable for all position welding. Power supply: direct current, electrode positive.

SPECIFICATIONS: AWS A5.11 ENiCrFe-3 (UNS W86182)
 ASME II, Part C, SFA-5.11, ENiCrFe-3 (UPIS W86182)
 ASME IX, F-No.43
 *DIN 1736 EL-NiCrISFeMn (2.4807)
 *(EN) I S 0 14172 - ENi6182 (NiCrISFebMn)

*Supply to these specifications available upon request For manufacture to ASME III (NCA3800, NB2400), MIL, and other specifications please refer your inquiry to the Technical Department prior to order placement.

TYPICAL CHEMISTRY:

Ni+Co	5.. 9.0 min.	Cu	0.50 max.
C	0.10 max.	Cr	13.0-17.0
Mn	5.0-9.5	Ti	1.0 max.
Fe	10.0 max.	Nb+Ta	1.0-2.5
S	0.015 max.	P	0.030 max.
Si	1.0 max.	Others	0.50 max.

TYPICAL MECHANICAL PROPERTIES:

Tensile Strength, psi	80,000
MPa	552
Elongation, (4d) %	30

AVAILABLE PRODUCT FORMS:

Diameter	mm	2.4	3.2	4.0	4.8
	in	3/32	1/8	5/32	3/16
Length	mm	229	356	356	356
	in	12	14	14	14
Current (DC+)	A	40-65	65-95	95-125	125-165

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

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