

## Classifications

EN ISO 18274

S Ni 6082 (NiCr20Mn3Nb)

AWS A5.14 / SFA-5.14

ERNiCr-3

## Characteristics and typical fields of application

Nickel-base solid wire TIG rod of S Ni 6082 (NiCr20Mn3Nb) / ERNiCr-3 for welding of many creep-resistant steels and nickel-base alloys. Well-suited for dissimilar welding of stainless and nickel alloys to mild steels. Can also be used as a buffer layer in many difficult-to-weld applications, where the high nickel content will minimize the carbon diffusion from the mild steel into the stainless material. Heat and high temperature resistant. Good toughness at subzero temperatures as low as -269°C. Service temperature limit is max. 900°C for fully stressed welds.

## Base materials

Suitable for high-quality weld joints of nickel-base alloys, joint welding of dissimilar steels and difficult-to-weld combinations including low-temperature steels up to 5% Ni, high-temperature and creep resistant materials, scaling resistant, unalloyed and high-alloyed Cr and CrNiMo-stainless steels. Dissimilar welding of 1.4583 X10CrNiMoNb18-12 and 1.4539 X2NiCrMoCu25-20 with ferritic pressure vessel boiler steels.

2.4816 NiCr15Fe, 2.4817 LC-NiCr15Fe, 1.4876 X10NiCrAlTi32-21

NiCr15Fe, X8Ni9, 10CrMo9-10

Alloy 600, 600L, 800, 800H,

UNS N06600, N07080, N0800, N08810

## Typical analysis of the wire rod

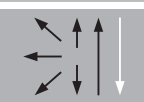
wt.-%	C	Si	Mn	Cr	Ni	Nb	Fe
	0.02	0.1	3.0	20	> 67.0	2.5	< 2

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact values ISO-V KV J	
	MPa	MPa	%	20°C	-269°C
u	400	620	35	150	32

u untreated, as-welded – shielding gas Ar

## Operating data



Dimension mm	Current A	Voltage V
1.0 × 1000	50 – 70	9 – 11
1.6 × 1000	80 – 120	10 – 13
2.0 × 1000	100 – 130	14 – 16
2.4 × 1000	130 – 160	16 – 18
3.2 × 1000	160 – 200	17 – 20

Preheating and post-weld heat treatment according to the parent metal. Attention must be paid to resistance to intercrystalline corrosion and embrittlement in case of austenitic stainless steels. To minimize the risk of hot cracking when welding fully austenitic and nickel-base alloys, heat input and interpass temperature must be low and there must be as little dilution as possible from the parent metal. Suggested heat input is max. 1.5 kJ/mm and interpass temperature max. 100°C.

Creep rupture properties according to matching high temperature steels / alloys up to 900°C.

Shielding gas: Ar. Gas flow: 8 – 12 l/min.

Polarity: DC-

## Approvals

TÜV (01703 / 08125), DB (43.132.11), DNV GL, CE