Technical data sheet 011121MBA	Coated SMAW Electrode # WA GAMMA 182-E	Welding Alloys

CLASSIFICATION

ASME II C SFA 5.11 / AWS A 5.11:	ENiCrFe-3
EN ISO 14172:	E-Ni6182 (NiCr15Fe6Mn)
UNS-base material:	W86182
Material number:	2.4620

DESCRIPTION

- Basic coated electrode giving a NiCrFe alloy deposit
- Joining and cladding of corrosion and heat resisting type 600 nickel alloys
- Dissimilar joints between stainless steels and CrMo steels
- Service temperatures from -196°C to +900°C
- Complements Welding Alloys cored wire GAMMA 182

APPLICATIONS

- Joining of heat resisting steels
- Joining and repair of steels with limited weldability

Base materials

UNS	Alloy	EN	Material N°
	5%Ni	12Ni19	1.5980
N06600	600	NiCr15Fe	2.4816
N08800	800	X10NiCrAlTi3220	1.4876
N08810	800H	X5NiCrAlTi3120	1.4958
	DS	X8NiCrSi3818	1.4862

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Si	Mn	Cr	Nb	Fe	Mo	Ni
<0.04	0.40	6.00	16.5	2.00	6.00	0.20	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	A_5 [%]	CVN [J]
650	380	40	+20°C: 110 -196°C: 70

OPERATING CONDITIONS

Electrode ØxL [mm]	2,5x300	3,2x350	4,0x350	5,0x450
Current [A]	50-70	70-95	90-120	120-170

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Re-drying: 1 h at 250-300°C. Joints to weld must be clean, exempt from grease, cracks.
Guide electrodes with a slight declination, weld with a short arc and prevent a high heat input by applying the stringer bead technique (weaving max. 2-3 times core wire diameter).

WELDING POSITIONS

EN ISO 6947: PA, PB, PC, PF, PE
ASME IX: 1G, 2G, 2F, 3G, 4G

PACKAGING

Electrode ØxL [mm]	2,5x300	3,2x350	4,0x350	5,0x450
Weight/box [kg]	4	5	5	6,5

Other packaging and other sizes: please consult us