



FCW NI182

*Rutile-basic cored wire
Alloy 600 type*

Classification

AWS A5.34 : ENiCrFe3T0-4

ISO 12153 : T Ni 6182 (NiCr15Fe6Mn) B M21 3

Description & Applications

Flux cored nickel base wire for gas shielded (Ar + CO₂) arc welding in flat position of high nickel alloys such as Inconel 600*, Incolloy 800*. Used for special austenitic stainless steels or dissimilar joining (Low alloy/ Stainless steel, Stainless Steel / Nickel Base). Good resistance to various types of corrossions. Could be used for cryogenic applications due to its high mechanical properties at low temperature.

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Main applications: Cladding on steels of 5% and 9% Ni. Equipment subject to acid very high temperature, repair of difficult to weld steels, buffer layer.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Fe	Cu	Nb+Ta	Ti	P	S	Ni
Min			5.0	13.0			1.0				59.0
Max	0.10	1.0	9.5	17.0	10.0	0.50	2.5	1.0	0.030	0.015	
Type	0.01	0.20	6.0	16.8	6.0	0.10	1.7	0.15	0.01	0.01	>59.0

Σ Others elements : <0.50

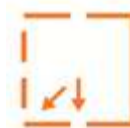
All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	360	550	25	
Max				
Type	380	610	40	-196°C 70

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.2	130 - 250	24 - 32	12 - 25	ISO 14175 : M21 (Ar/CO ₂) 10 - 20 l/min
	1.6	150 - 300	24 - 32	12 - 25	

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