



TIG 6082



Standards

AWS 5.14

ERNiCr-3

EN ISO 18274

Ni 6082

W. Nr.

2.4806

Description & applications

Nickel-based filler metal in solid wire sticks for TIG welding of Nickel-Chromium alloys type Inconels 600, 601, Incoloy 800 and Alloy 330. This Nickel-based alloy, frequently called « Alloy 82 », has an excellent behavior from cryogenic conditions up to high temperatures, with a good resistance to creep due to its Niobium content.

It is also used for the welding of 9 % Ni steels in cryogeny et heterogeneous welding in high temperature applications.

Typical chemical composition (%)

C max	Mn	Si	Cr	Ni	Nb	S max	P max	Fe
0.05	3.0	0.5	20.5	Base	2.5	0.02	0.02	3.0

Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV -196°C
660MPa	410 MPa	35%	60 J

Operating parameters

Shielding gas recommendations:

EN ISO 14175 II : 100 % Argon : 6-12 l/mn Root: Argon, Nitrogen : 3-6 l/mn



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