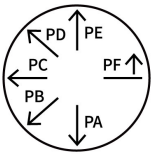


SR-182

Classification

AWS A5.11/ASME SFA-5.11 ENiCrFe-3
JIS Z 3224 DNiCrFe-3
EN ISO 14172 Ni 6182

Welding Positions



Features

- Good crack resistance
- Good arc stability and good slag removal
- Good bead appearance

Polarity

DC +, AC

Application Areas

- Inconel 600, 601 and stainless steels & low-alloy steel & nickel-alloy steel.
- Ni-Cr-Fe alloy clad steels

Redrying Conditions

250~300℃(482~572℉) X 2~3hr

Approvals

ABS
✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Ni	Cr	Ti	Nb_Ta	Fe
0.06	0.44	5.7	0.013	0.010	73.0	14.8	0.01	1.7	3.8

Typical Mechanical Properties of All-Weld Metal

Tensile Strength MPa(ksi)	Elongation (%)	Temperature ℃ (°F)	Impact Toughness J (ft · lbs)	LE(mm)
560(81)	33	0(32) -196(-320)	100(74) 76(56)	0.93

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6 (3/32)	300 (12)	60~90	60~90	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
3.2 (1/8)	350 (14)	70~115	65~110	
4.0 (5/32)	350 (14)	100~140	100~130	
5.0 (3/16)	350 (14)	120~160	110~140	

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux