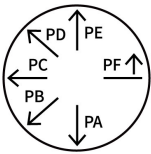


SR-182

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

Diameter / Welding Parameters / Packaging

| Diameter<br>mm(in) | Length<br>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  |                                                 |

SMAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux