

Nickel alloy Covered Electrodes

KW-A82M

For Cement industry

Classifications

EN ISO 14172:2004 : E Ni 6082
AWS A5.11-05 : ENiCrFe-3(mod.)

Description

- Covering is low hydrogen type for welding of Ni-Cr-Fe alloy steel or different materials, such as Inconels, Inconel and low alloy steels, stainless steels and low alloy steels.
- Excellent heat resistance, corrosion resistance and mechanical quality of all weld metal.
- Redry the electrode at 300~400°C for 1~2 hours prior to use.

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Fe	Ni	Cr	Mo	Nb+Ta
0.04	0.34	4.24	0.003	0.010	2.96	Rem.	20.20	1.73	1.95

Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
EN ISO 14172	min. 360	min. 600	min. 22	
Example	430	690	47	AW

* AW : As-Welded

Sizes available and recommended currents (DC+)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	300	350	350
Amp. (A)	F V-OH	60~80 50~70	80~120 70~100	120~150 100~140	150~180 -