Inweld Alloy 182

AWS A5.11 ENiCrFe-3

Chemical Composition of Inweld Alloy 182

Fe	C	Cr	Ni	N	Ti	Si	P	S	Nb (Cb) & Ta	Other
10.0	0.10	13.0-17.0	59.0 Min	---	1.0	1.0	0.03	0.015	1.0-2.5	0.50

Single values are maximum unless otherwise specified.

Description and Applications

Inweld Alloy 182 is a "General Purpose" nickel-chromium-iron flux-coated electrode used for joining dissimilar combinations of nickel base alloys to themselves or to stainless or mild steels. Inweld Alloy 182 consistently produces x-ray quality and machine-able weld deposits. Excellent for welding: Inconel®600 to itself, or to carbon steel, and stainless steel; Incoloy®800 to nickel-copper Monel®400, or nickel base alloy 200; Nickel base alloy 200 to stainless steel; Nickel-copper Monel®400 to carbon steel. Inweld Alloy 182 is so versatile; it can be used for countless applications. The most common applications can be found in the chemical or petrochemical industries and the nuclear industry where it is used to weld dissimilar joints between vessels and primary piping. It is also used for welding the clad side of nickel-chromium-iron clad steel and for re-surfacing steel.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	80,000 psi
Yield Strength:	45,000 psi
Elongation:	30%

Recommended Parameters

SMAW (DCEP – Electrode+)

Wire Diameter	Voltage	Amperage
3/32"		75-100
1/8"		100-140
5/32"		140-180
3/16"		170-210