



182/625

Nickel alloy solid wires for submerged arc welding

Nickel alloy solid wires for use in combination with Semi basic submerged arc fluxes.

International Standards

	BS EN ISO 18274:2004	AWS A5.14 - 97
182	S Ni 6082 (NiCr20Mn3Nb)	ER NiCr-3
625	S Ni 6625 (NiCr22Mo9Nb)	ER NiCrMo-3

Typical Wire Analysis (wt%)

	C	Si	Mn	Cr	Ni	Nb	Fe	Cu
182	0.010	0.4	3.0	20.0	Bal	2.4	0.9	0.1
625	0.025	0.3	4.0	21.0	Bal	3.5	<2.0	-

Mechanical Properties

Dependant upon flux wire combination.

Materials

182	Inconel 600, ASTM B163, B166, B167, B168 & UNS N06600
625	Inconel 625, 800, 825 Avesta 254SMo, ASTM B444, B446 and UNS N06625

Packaging

Size mm	1.6	2.4	3.2	4.0
25 kilo reel	✓	✓	✓	✓

Additional Information

Certification	BS EN 10204:2004 Type 3.1
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