

TALWELD 82

Comparable specifications

ASME SFA A 5.14: ERNiCr-3
EN ISO 18274: Ni 6082 - NiCr20Mn3Nb
BS 2901: Pt 5 NA 35
Werkstoff Nr.: 2.4806

Description and applications*

* *Illustrative, not-exhaustive list*

This grade may be used for:

- welding of nickel-chromium alloys and nickel-chromium-iron alloys;
- surfacing of steel with nickel-chromium-iron weld metal;
- joining of steel to stainless steel or nickel-base alloys;
- cladding and welding of dissimilar metal joints (this alloy to steel, to copper/nickel and to other nickel alloys);
- overlaying itself on steel;
- cryogenic applications;
- applications at elevated temperature, e.g. petrochemical and power generation plants.

Weldable base materials*

* *Illustrative, not-exhaustive list*

Alloy 600, Alloy 601, Alloy 690, Alloy 800, Alloy 330

All-weld metal mech. properties*

* *For reference only values*

Tensile strength (Rm): ≥ 600 N/mm² **Yield Strength (Rp_{0.2}):** ≥ 360 N/mm²
Elongation: $\geq 30\%$ **Charpy-V Impact (R.T.):** ≥ 100 J

Chemical composition*

* *For reference only values*

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Ti	Cr	Nb+Ta
max	2.50	max	max	max	max	max	67.00	max	max	18.00	2.00
0.05	3.50	3.00	0.030	0.015	0.50	0.50	min	1.00	0.75	22.00	3.00

Wire Diam.	15 kg Spool	5 kg Tube
0.9mm	NMM8209	
1.2mm	NMM8212	
1.6mm		NMT8216
2.4mm		NMT8224

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