

**MMA Welding Electrode Selction Chart for High Ni Alloys**

	Copper-Nickel alloys	Cast High Temp alloys	Duplex and Super Duplex	Austenitic stainless steels	3 - 30% Cr steels	Carbon and low alloy steels	Ni Steels	Incoloy 825	Incoloy 803, 800, 800H/HT	Inconel 686	Inconel 625	Inconel 600	Monel 400
Nickel 200	Monel 190	Incoweld A Inconel 112 Inconel 182	Incoweld A	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112 Inconel 182	Incoweld A	Incoweld A Inconel 112 Inconel 182	Incoweld A	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112 Inconel 182	Monel 190
Monel 400	Monel 190	Incoweld A Inconel 112 Inconel 182	Incoweld A	Incoweld A Inconel 112 Inconel 182 Monel 190	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112 Inconel 182 Monel 190	Incoweld A Inconel 112 Inconel 182 Monel 190	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112	Incoweld A Inconel 112	Incoweld A Inconel 112 Inconel 182	Inconel 112 Monel 90
Inconel 600	Incoweld A Inconel 182	Incoweld A Inconel 117	Incoweld A	Incoweld A Inconel 112 Inconel 117 Inconel 182	Incoweld A Inconel 112 Inconel 117	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112 Inconel 117	Incoweld A	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 182	
Inconel 625	Incoweld A Inconel 112	Incoweld A Inconel 117	Inconel 112	Inconel 112	Incoweld A Inconel 112	Incoweld A Inconel 112	Incoweld A Inconel 112	Inconel 112	Incoweld A Inconel 112 Inconel 117 Inconel 182	Inconel 112	Inconel 112		
Inconel 686		Inconel 117		Incoweld A Inconel 182	Incoweld A Inconel 182	Incoweld A Inconel 182	Incoweld A Inconel 182	Inconel 112	Incoweld A				
Incoloy 803, 800, 800H/HT	Incoweld A Inconel 182	Incoweld A Inconel 117	Incoweld A	Incoweld A Inconel 112 Inconel 117	Incoweld A Inconel 117	Incoweld A Inconel 117	Incoweld A Inconel 117	Incoweld A Inconel 112	Incoweld A Inconel 117				
Incoloy 825	Incoweld A Inconel 182	Incoweld A Inconel 112	Inconel 112	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112 Inconel 182	Inconel 112					
Ni Steels	Incoweld A Inconel 182 Monel 190	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 182	Incoweld A Inconel 112 Inconel 182	Incoweld A Inconel 112	Incoweld A Inconel 112	Incoweld A Inconel 112	Incoweld A Inconel 112					
Carbon and low alloy steels	Incoweld A Inconel 182 Monel 190	Incoweld A Inconel 112 Inconel 182	See dissimilar steels chart	See dissimilar steels chart	Incoweld A Inconel 112	See mild, low alloy steel charts							
3 - 30% Cr steels	Incoweld A Inconel 182	Incoweld A Inconel 112 Inconel 117	Incoweld A	Incoweld A Inconel 112 Inconel 182	Inconel 112								
Austenitic stainless steels	Incoweld A Inconel 182	Incoweld A Inconel 112 Inconel 117	See Stainless steel chart	See Stainless steel chart									
Duplex and Super Duplex	Incoweld A	Incoweld A	See Stainless steel chart										
Cast High Temp alloys	Incoweld A Inconel 117	Incoweld A Inconel 117											