

**GMAW Wire 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
<b>Nickel 200</b>	Monel 67	Inconel 82	Inconel 82	Inconel 82	Inconel 82	Inconel 82	Inconel 82	Inconel 625 Inconel 82	Inconel 82	Inconel 82	Inconel 625 Inconel 82	Inconel 82	
<b>Monel 400</b>	Monel 67	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82
<b>Inconel 600</b>	Inconel 82	Inconel 625 Inconel 82	Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 82	
<b>Inconel 625</b>	Inconel 625 Inconel 82	Inconel 625 Inconel 82		Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625	Inconel 625 Inconel 82	Inconel 625	Inconel 625		
<b>Inconel 686</b>	Inconel 625	Inconel 82		Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625	Inconel 625 Inconel 82				
<b>Incoloy 803, 800, 800H/HT</b>	Inconel 82	Inconel 625 Inconel 82	Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 82				
<b>Incoloy 825</b>	Inconel 82	Inconel 625 Inconel 82	Inconel 625	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625					
<b>Ni Steels</b>	Inconel 82	Inconel 625 Inconel 82	Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82						
<b>Carbon and low alloy steels</b>	Inconel 82	Inconel 625 Inconel 82	See dissimilar steels chart	See dissimilar steels chart	Inconel 625 Inconel 82	See mild, low alloy steel charts							
<b>3 - 30% Cr steels</b>	Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82	Inconel 625 Inconel 82								
<b>Austenitic stainless steels</b>	Inconel 82	Inconel 82	See Stainless steel chart	See Stainless steel chart									
<b>Duplex and Super Duplex</b>	Inconel 82	Inconel 82	See Stainless steel chart										
<b>Cast High Temp alloys</b>	Inconel 82	Inconel 82											
<b>Copper-Nickel alloys</b>	Monel 67												