

MIDALLOY ERNiCr-3 (FM82) BARE WIRE

CLASSIFICATION

- AWS 5.14 Class ERNiCr-3 / ASME SFA 5.14 Class ERNiCr-3

DESCRIPTION

- MIDALLOY ERNiCr-3 nickel alloy bare wire is used for GMAW, GTAW, and SAW welding.

APPLICATIONS

- MIDALLOY ERNiCr-3 nickel alloy bare wire is used for joining base materials such as UNS number N06600. This includes ASTM grades B163, B166, B167, and B168.
- This alloy can also be used for dissimilar welding using various nickel alloys to stainless steels or carbon steels, as well as for overlaying carbon steels.
- Also used for welding 9% nickel steels to one another having high impact strength at low temperatures.
- This versatile alloy has high strength and good corrosion resistance, with oxidation resistance and creep-rupture strength at elevated temperatures.

TYPICAL CHEMISTRY

C	Mn	Fe	P	S	Si	Cu
.02	3.0	0.40	.007	.003	.041	.009
Ni	Al	Ti	Cr	Cb + Ta	Co	Others
70.5	.05	.30	20.5	2.3	.012	<.5

TYPICAL MECHANICAL PROPERTIES

TENSILE STRENGTH	85,000 PSI
YIELD STRENGTH	52,000 PSI
ELONGATION	38%

RECOMMENDED WELDING PARAMETERS

(See attached)

STANDARD PACKAGING

- TIG 10 lb. tube / 60 lb. carton
- MIG 30 lb. spool
- SUB-ARC 60 lb. coil

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