

## MIDALLOY MASTERCOR ENiCr-3FC AP FLUX-CORED WIRE

### CLASSIFICATION

- Chemistry conforms to AWS/SFA 5.34. The AWS classification for this flux-cored wire is Class ENiCr-3T1-4 for Argon-CO<sub>2</sub> shielding gas and ENiCr-3T1-1 for 100% CO<sub>2</sub> shielding gas.

### DESCRIPTION

- MIDALLOY MASTERCOR ENiCr-3FC AP is an all-position flux-cored nickel alloy wire with a variety of uses in the welding field.
- UNS# W86082
- ISO# TNi6082-xy
- This wire offers excellent arc stability, with little spatter and easy slag removal.

### APPLICATIONS

- MIDALLOY MASTERCOR ENiCr-3FC AP is used for welding nickel alloys of similar chemistry, overlay welding, and welding of dissimilar metals.

### TYPICAL CHEMISTRY

C	Mn	Si	Cr	Fe	Cb + Ta	S	P	Ni
0.04	3.0	0.04	18.2	1.5	2.7	0.003	0.010	BAL.

### TYPICAL MECHANICAL PROPERTIES\*

TENSILE STRENGTH	89,000 PSI
YIELD STRENGTH	68,000 PSI
ELONGATION IN 2"	26%

\*These properties were generated using 75% Argon – 25% CO<sub>2</sub>. 100% CO<sub>2</sub> values are available upon request.

### WELDING PARAMETERS

SIZE	VOLTS	AMPS	STICKOUT	SHIELDING GAS
.045"	25-28	140-200	½"	75 Ar/25 CO <sub>2</sub> or 100% CO <sub>2</sub>
1/16"	26-28	190-230	½"	75 Ar/25 CO <sub>2</sub> or 100% CO <sub>2</sub>

**Note:** Must use 75/25 for overhead and vertical. Optimum vertical 140 amps-25 volts.

### STANDARD PACKAGING

- 33 lb. spool

12-1-08

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