

## MIDALLOY MASTERCOR ENiCrFe-3 AP FLUX-CORED WIRE

### CLASSIFICATION

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

### DESCRIPTION

- MIDALLOY MASTERCOR ENiCrFe-3 is a flux-cored nickel alloy welding wire designed for all position welding.
- UNS# W86182
- ISO# 6182-xy
- This wire offers excellent arc stability with little spatter and easy slag removal.

### APPLICATIONS

- MIDALLOY MASTERCOR ENiCrFe-3 is used for welding nickel, chrome and iron alloys of similar composition.
- It is especially suited for welding alloys 600, 601 and 800 to themselves or to stainless and carbon steels.
- This wire can also be used to overlay carbon steel and to create a nickel, chromium, iron-welded surface.

### TYPICAL CHEMISTRY

C	Mn	Si	Cr	Fe	Nb	S	P	Ni
0.03	5.4	0.03	16.0	7.5	2.0	0.004	0.010	BAL.

### MECHANICAL PROPERTIES

TENSILE STRENGTH	94,000 PSI
YIELD STRENGTH	58,000 PSI
ELONGATION IN 2"	35%

### WELDING PARAMETERS

SIZE	VOLTS	AMPS	STICKOUT	SHIELDING GAS
.045" DIA.	25-26	150-200	½"	75 Ar / 25 CO <sub>2</sub> or 100% CO <sub>2</sub>
1/16" DIA.	26-27	150-275	½"	75 Ar / 25 CO <sub>2</sub> or 100% CO <sub>2</sub>

### STANDARD PACKAGING

- 33 lb. spool

12-1-08

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