

Nickel Base Alloy MIG•TIG Wire/Rod

GTN82 / GMN82

AWS A5.14 ERNiCr-3
ISO 18274-S Ni 6082
JIS Z 3334 S Ni6082

Product Features:

- Good heat, corrosion resistance and good mechanical properties of weld metal.

Applications:

- Welding of similar grade of nickel base alloy.
- Welding overlay to carbon, low alloy steel, stainless and Ni steels.

Shielding gas:

- Ar + 0.5~2.0%O₂ or 100%Ar (GMAW)
- 100% Ar (GTAW)

Typical chemical composition of wire / rod (wt%)

C	Si	Mn	Ni	Cr	Nb	Fe	Ti
0.011	0.10	3.24	75	18.58	2.70	0.17	0.43

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
704	44

MIG wire size (mm) & recommended welding parameters (A)

Diameter	0.9/1.0	1.2	1.6
Current range	70~180	130~230	180~280

TIG rod size diameter/length

Diameter (mm)	1.6	2.0	2.4	3.2
Length (mm)	1000	1000	1000	100

Note:

Recommend pulse or spray arc (low current) for RT examination purpose.

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