

**Technical
data sheet**

011121MBA

**Cored welding wire
GAMMA 182****CLASSIFICATION**

AWS A 5.34 / AWS A 5.34M: ENiCrFe3T0-4 / TNi6182-04
EN ISO 12153: T Ni 6182 (NiCr15Fe6Mn) B M21 3

DESCRIPTION

- Flux cored nickel based wire for gas shielded arc welding and self shielded arc welding (open arc)
- Latest generation basic slag quality guarantees optimum metallurgical quality and attractive welder appeal
- Meets the NiCrFe-3 requirements
- Together with enhanced productivity, GAMMA 182 offers many other advantages compared to solid wires : improved wetting properties, increased resistance to cracking, better bead aspect and shape.
- Maximum performance in the horizontal and flat positions
- Using a classical M21 gas mixtures (Ar + 15 - 25% CO₂) will improve the bead appearance

APPLICATIONS

- GAMMA 182 is suitable for welding and cladding nickel-based alloys such as alloy 600 or similar materials.
- It is also used for dissimilar welding of most nickel-based alloys to each other, to alloyed steels, or to stainless steels.
- Repair welding on "hard-to-weld" steels.
- No embrittlement after heat treatment

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Nb	Fe	Ni
0.01	6.0	0.3	17.0	1.7	6.0	Bal.

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
550	360	27	+20°C: 70

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

	Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
M21 gas mixture	610	380	40	-196°C: 90
Open arc	610	380	35	+20°C: 100

OPERATING CONDITIONS

Diameter [mm]	Current type	Amperage [A]	Voltage [V]	Stick-out [mm]
1.2	DC+	130 - 250	24 - 32	12 - 25
1.6	DC+	150 - 300	24 - 32	12 - 25

WELDING POSITIONS

Flat, Horizontal

PACKAGING

Diameter	1.2 mm	1.6 mm
Spool type	EN ISO 544 – ASME IIC SFA-5.2 M: BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.