

CARBO F-Ni 182 B



DIN EN 14700 T Ni6182 (NiCr15FeMn)
AWS A 5.34 ENiCrFe3T0-4
AWS A 5.34M - 2007 TNi6182-04

General characteristics

CARBO F-Ni 182 B is nickel base tubular wire, suitable for joining and cladding nickel-based alloys such as alloy 600 or similar materials. CARBO F-Ni 182 B has an excellent performance in horizontal and downhand positions. The austenitic deposit is insensitive to hot-cracking and free of embrittlement at high as well as at low temperatures, nonscaling up to 1000° C, and cold tough down to -196° C. No diffusion of carbon into the weld metal at high temperatures.

Typical applications

Used for service-temperatures of more than 300° C in Chemical Industry, Petrochemical Industry, glassworks, civil engineering, repairing and maintenance workshops.

Weld metal analysis (typical, wt %)

	C	Si	Mn	Cr	Ni	Nb	Fe			
Gew-%	0,01	0,3	6,0	17,0	Basis	1,7	6,0			

Base materials

2.4640 NiCr15Fe (Alloy 600)	1.4876 X10NiCrAlTi32 21 (Alloy 800)	1.4958 X5NiCrAlTi 31 20 (Alloy 800H)	1.4864 X12NiCrSi 36 16 (Alloy 330)
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Mechanical properties of all-weld metal (typical values)

Tensile strength R_m Mpa:	610			
Yield strength $R_{p0.2}$ Mpa:	380	Impact strength ISO-V KV J at	-196°C	90 J
Elongation A ($L_0 = 5d_0$):	45			

Operating data

Current:	=+
Gas types EN ISO 14175:	M21: AR + 15 - 25 % Co ²

Dia (mm)	DIA (inch)	Volt	Amps	Delivering form
1,2	3/64	24 - 32	120 - 250	G *
1,6	1/16	18 - 27	150 - 300	G *

Delivering form

O * = gasless (open arc), G * = gas shielded, S * = Submerged Arc

Coil "BS 300" = 15 kg	Coil "BS 450" = 25 kg	Drums = 300 kg
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Statements on composition and application are just for the appliers information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.