



Masterweld 82 (ERNiCr-3)

Comparable specifications

ASME SFA A 5.14: ERNiCr-3
EN ISO 18274: Ni 6082 - NiCr20Mn3Nb
BS 2901: Pt 5 NA 35
Werkstoff Nr.: 2.4806

Description and applications*

* Illustrative, not-exhaustive list

This grade may be used for:

- welding of nickel-chromium alloys and nickel-chromium-iron alloys;
- surfacing of steel with nickel-chromium-iron weld metal;
- joining of steel to stainless steel or nickel-base alloys;
- cladding and welding of dissimilar metal joints (this alloy to steel, to copper/nickel and to other nickel alloys);
- overlaying itself on steel;
- cryogenic applications;
- applications at elevated temperature, e.g. petrochemical and power generation plants.

Weldable base materials*

* Illustrative, not-exhaustive list

Alloy 600, Alloy 601, Alloy 690, Alloy 800, Alloy 330

All-weld metal mech. properties*

* For reference only values

Tensile strength (Rm): $\geq 600 \text{ N/mm}^2$ **Yield Strength (Rp_{0.2}):** $\geq 360 \text{ N/mm}^2$
Elongation: $\geq 30\%$ **Charpy-V Impact (R.T.):** $\geq 100 \text{ J}$

Chemical composition*

* For reference only values

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Ti	Cr	Nb+Ta
max	2.50	max	max	max	max	max	67.00	max	max	18.00	2.00
0.05	3.50	3.00	0.030	0.015	0.50	0.50	min	1.00	0.75	22.00	3.00

