Inweld NA 182

AWS A5.11 ENiCrFe-3

Chemical Composition of Inweld NA 182

C	Mn	Fe	P	S	Si	Cu	Ni	Cr	Nb (Cb) & Ta	N	Other
0.10	5.00-9.50	10.0	0.03	0.015	1.0	0.50	59.0 min	13.0-17.0	1.00-2.50	---	0.50

Single values are maximum unless otherwise specified.

Description and Applications

Inweld NA 182 electrodes are used for welding of nickel-chromium-iron alloys to themselves, and for dissimilar welding between nickel-chromium-iron alloys and steels or stainless steels. The applications include surfacing as well as clad-side welding. High manganese of this weld deposit reduces the possibility of micro fissures. High manganese reduces creep strength, which limits its usage up to 900°F. Manufactured under Quality System approved by ASME, ISO9001. Meets AWS 5.11 Class ENiCrFe-3.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	80,000 psi
Yield Strength:	50,000 psi
Elongation:	30%

Recommended Parameters

SMAW

Wire Diameter	Voltage	Amperage
3/32”		65-75
1/8”		90-105
5/32”		120-135
3/16”		135-155