

SW-82 Cored

Conformances

AWS A5.34/ ASME SFA5.34 ENiCr3T1-1/-4
EN ISO 12153 T Ni 6082 P M/C 2

Applications

- Dissimilar welding(stainless steel, heat resisting steel)

Features

- Designed for welding with 100% CO₂ or Ar+15~25% CO₂ shielding gas
- Excellent all position weldability
- Smooth and stable arc with a fast freezing slag

Welding Position

Current

DC +

Shielding Gas

100% CO₂ / Ar+20~25% CO₂

Diameter / Packaging

Diameter mm (in)	Length mm(in)	
	12.5kg (28lbs)	15kg (33lbs)
1.2 (0.045)	√	√
1.4 (0.052)		
1.6 (1/16)		

Typical Chemical Composition of All-Weld Metal(%)

C	Si	Mn	P	S	Cr	Ni	Nb	Fe
0.044	0.21	3.1	0.001	0.004	20.6	71.3	2.42	2.26

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
-	665	42.8	-196 (-321)	100 (74)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Amp. (A)	Volt. (V)	Deposition Rate kg/hr (lb/hr)
1.2mm (0.045 in) DC+					
100% CO ₂	20 (4/5)	6.0 (236)	140	23~26	2.5 (5.5)
		9.2 (362)	180	27~30	3.4 (7.5)
		12.0 (472)	210	28~31	4.5 (9.9)
80% Ar+20% CO ₂	20 (4/5)	6.1 (240)	140	23~26	2.6 (5.7)
		9.0 (354)	180	27~30	3.6 (7.9)
		11.5 (453)	210	27~30	4.6 (10.1)

SMWV

SAW

GMWV

GTAW

FCWV

Non-FERROUS

APPENDIX