

Classification: Description: Cromarod 82 is a basic flux coated nickel-base electrode intended for welding EN ISO 14172 E Ni 6082 Inconel 600 and similar composition alloys. The deposit tolerates high dilution AWS A5.11 E NiCrFe-3(mod.) levels and is very resistant to hot cracking. It is not susceptible to sigma Approvals: phase embrittlement or carbon migration and is therefore ideal for service at elevated temperatures. ΤÜV Cromarod 82 is highly suitable for a wide range of dissimilar joint CE combinations between nickel-base alloys, Monels, mild and low alloy steels and austenitic stainless steels. It can also be used to clad carbon steels with an Inconel type surface. The weld metal exhibits very good fracture toughness at temperatures down to -196 °C and is suitable for welding 5% Note and 9% nickel steels for cryogenic applications. AWS: Slight deviation in Cr compared to E NiCrFe-3 Welding positions: Π Coating type: Basic Welding current: DC + Ferrite content: FN 0 (WRC-92) **Corrosion resistance** Very good resistance to general and intergranular corrosion. Very good resistance to stress corrosion cracking. High temperature properties: The weld metal is resistant to oxidation - in air up to 1150 ℃ - in sulphur dioxide up to 800 °C - in hydrogen sulphide up to 550 ℃ Yield strength at 800 ℃ is approx. 190 MPa. Redrying temperature: 350 °C, 2h Chemical composition, wt.% Ρ С Si Mn Cr Ni S Min 18.0 63,0 0,2 4,0 Typical 0,03 0,4 5,5 0,005 0,005 18,5 bal. Max 0,10 0,60 6,0 0,020 0,015 22.0 Мо Cu Nb Fe Min 1,5 Typical 1.1 2,2 3,5 2,0 0,5 3,0 4.0 Max Mechanical properties Specified Typical Yield strength, Rp0.2%: ≥ 380 MPa 400 MPa Tensile Strength, Rm: ≥ 620 MPa 650 MPa Elongation, A5 ≥ 35% 40% Impact energy, CV: 20 °C • ≥ 80 J -196 ℃ • 60 J

Produkt data:

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/	No. of electrodes/	Kg weld metal/	Burn-off time/
					kg electrodes	kg weld metal	hour arc time	electrode (sec.)
2,5	300	74542500	50-70	25-27	0,60	100	0,8	46
3,2	300	74543200	70-95	25-27	0,62	58	1,1	59