

## AI-0382T

### Specifications

**AWS/ASME** A5.14 : ER NiCr- 3

**MIL-E-21562** Types **MIL-RN82**, **MIL-EN82**

**SFA-5.14** Class ERNiCr-3

### Description and Applications

**AI-0382T** is a **Nickel based** filler wire used in the joining and cladding of similar materials such as Inconel 600, 601 and Incoloy™ 800.

**AI-0382T** is recommended for dissimilar welding applications such as Inconel to Nickel 200, Monel™ 400, stainless steels and carbon steels.

This consumable can be used for materials, which operate at extremes of temperature from 196°C to 900°C. **AI-0382T** gives a fully austenitic weld metal that withstands hot cracking.

### Typical Weldmetal Analysis

C	Cu	Mn	Si	Cr	Ni	Fe	Other	Co	Ti	Nb
0.05	0.5	2.5-3.5	0.5	18-22	Bal.	3.0	0.05	0.10	0.75	2.0-3.0

### Mechanical Properties of Weldmetal

	As Welded
Yield Strength 0.2%	360MPa
Tensile Strength	600Mpa
Elongation A5	30%
Impact Strength	100 J/cm <sup>2</sup>

### Welding Instructions

Shielding Gas: Argon 100% or Oxy-Acetylene

Gas Rate 15-18 l/min

### Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at [sales@alloysint.com.au](mailto:sales@alloysint.com.au)

