

20.70.Nb

TIG (GTAW)

SOLID ROD FOR TIG

PRODUCT DESCRIPTION

Solid rod for TIG welding of nickel base alloys and dissimilar joints between nickel alloys, ferritic and austenitic stainless steels.

CLASSIFICATIONS

AWS A5.14M ERNiCr-3
ISO ISO 18274 S Ni 6082
UNS N06082
APPROVALS TÜV
Also known generically as filler metal 82 [FM82]

ASME IX QUALIFICATION

QW432 F-No 43

CHEMICAL COMPOSITION [WIRE WT %]

	C	Mn	Si	S	P	Cr	Ni	Nb	Cu	Ti	Fe
min.	--	2.5	--	--	--	18.0	670	2.0	--	--	--
max.	0.05	3.5	0.50	0.015	0.020	22.0	bal	3.0	0.50	0.7	3.0
Typical	0.02	3	0.1	0.005	0.01	20	73	2.5	0.01	0.4	1

ALL-WELD MECHANICAL PROPERTIES

Typical values as welded	RT
Tensile strength [MPa]	650
0.2% proof strength [MPa]	390
Elongation [%] 4d	50
5d	45
Reduction of area [%]	60
Impact ISO-V(J) -196°C	> 100

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter [mm]	Parameters
Argon	DC-	2.4	100A, 12V

PACKAGING DATA

Diameter [mm]	Weight [kg]	Packaging	Item number
1.6	2.5	PE TUBE	T2070NB-16
2.0	2.5	PE TUBE	T2070NB-20
2.4	2.5	PE TUBE	T2070NB-24
3.2	2.5	PE TUBE	T2070NB-32

NICKEL BASE ALLOYS