

INCO-CORED 82DH & 82AP Flux Cored Wire

INCO-CORED 82DH and 82AP Flux Cored Wires are identical in chemistry and properties to the bare wire INCONEL Filler Metal 82. They have excellent weldability, and benefit from the higher deposition rates associated with flux-cored wires. Both use a shielding gas of 75% Argon and 25% Carbon Dioxide.

"DH" designation is for 'Down-Hand' welding or flat position (1G). "AP" designates 'All Position' welding optimized for horizontal and vertical welding. The products are used to weld INCONEL alloys 600 and 601, INCOLOY alloys 800 and 800HT, and INCOLOY alloy 330. They are also used in many dissimilar metal applications, especially where carbon steels are joined to stainless steels and to nickel-based alloys. Weld overlaying of carbon and low alloy steels is another popular application for INCO-CORED 82DH and 82AP Flux Cored Wire.

Power supply: direct current, electrode positive.

Specifications

The products have been proposed to AWS and are expected to be listed in AWS A5.34 as ENiCr3T0-4 and ENiCr3T1-4. Other specifications will follow.

Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Typical Chemical Composition (%)	Ni.....	72	C	0.04
	Cr	19	Ti	0.25
	Mn	3	S	<0.01
	Nb	2.5	Si.....	0.3
	Fe	2.5	P	<0.01
	Al.....	0.05	Others	<0.5
	Cu	0.05		

Minimum Mechanical Properties	Tensile Strength, psi	80,000
	MPa	552
	Elongation, (4d) %	30

Available Product Forms

mm	**1.14	**1.6	*2.4
in	0.045	0.062	0.093

*0.093 on traverse wound 30 lb. masonite spools

**0.062 and 0.045 on level layer wound 30 lb. wire basket spools

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