

Wire and Welding products

HAYNES
Wire Company



HAYNES® 182 Coated Electrodes

Product Description:

HAYNES® 182 coated electrodes are used for shielded metal arc welding of alloys 600 and 601. The weld metal has good corrosion resistance, excellent high temperature strength and oxidation resistance. The 182 electrode is a good candidate for dissimilar joints between HAYNES® and HASTELLOY® alloys joined to carbon and stainless steels, nickel alloys joined to stainless steels and carbon low alloy steels joined to stainless steels. The electrode coating has outstanding operability, especially in out-of-position welding.

Specifications:

AWS A5.11 ENiCrFe-3
ASME SFA.5.11 ENiCrFe-3

ASME IX F-43
UNS W86182

Weld Deposit Chemistry:

Ni.....59 min.
Cr.....13.0 - 17.0
Co.....*0.12 max.
Ti.....1.0 max.
Fe.....10.0 max.
Mn.....5.0 - 9.5
Nb + Ta.....1.0 - 2.5

Si.....1.0 max.
Cu.....0.5 max.
Other.....0.5 max.
C.....0.1 max.
P.....0.03 max.
S.....0.015 max.

*When specified by customer

Minimum Mechanical Properties:

Tensile (psi) 80,000
Mpa 550
Elongation (%) 30

Available Product Forms:

Diameter (in)	.093 (3/32)	.125 (1/8)	.156 (5/32)	.187 (3/16)
Length (in)	10	14	14	14
Pkg Wt (lbs)	5	10	10	10
Current (A) DCEP	40-70	70-100	80-140	120-150

Packaged in Hermetically Sealed Containers

HW-7007

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