

Applications

SR-182 is designed for welding of Inconel 600 + 601 and dissimilar welding of stainless steels and low-alloyed steel & Nickel-alloyed steel. It can be used for welding of Ni-Cr-Fe alloyed clad steel as well.

Characteristics on Usage

SR-182 has an excellent crack resistibility due to high portion of Mn of weld metal. Arc & slag stability make good bead appearance as well. In practice welding, superior anti-heat feature enables better productivity.

Notes on Usage

- ① Remove rust, scales, oil, paint, slag of tack welds.
- ② Keep the arc as short as possible.
- ③ Dry the electrodes at 350~450°C(662~842°F) for 60 minutes before use.
- ④ Keep the welding current as low as possible.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

AC or DC +

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Nb+Ta	Fe
0.060	0.45	6.20	0.010	0.010	16.5	72.0	1.8	5.2

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
640 (93,300)	40	-196 (-321)	76 (56)

Approval

I Packing

Packet 2.5 kg (5.5 lbs)
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	3.2 (1/8)	4.0 (5/32)
Length mm(in)	350 (14)	350 (14)
F	70 - 115	95 - 150
V-up, OH	65 - 110	85 - 135