



# S. R. Industries

## STAR ARC ENiCrFe-3

*Type 182 electrodes (ENiCrFe-3) are used for welding of nickel-chromium-iron alloys to themselves and for dissimilar welding between nickel-chromium-iron alloys and steels. Its high manganese content lessens the possibility of micro fissures and also reduces creep strength which limits its usage up to 900°F. Applications for this alloy include surfacing as well as clad-side welding.*

**AWS Specification :** A5.11/A5.11M:2010

AWS Classification		ENiCrFe-3		Welding Current		DCEP						
<b>Typical Wire Chemistry</b>												
C	Mn	Fe	P	S	Si	Cu	Ni <sub>b</sub>	Ti	Co	Cr	Nb (Cb) plus Ta	other
0.10	5.0-9.5	10.0	0.03	0.015	1.0	0.50	59.0 min	1.0	d	13.0-17.0	1.0-2.5	0.50
Typical Mechanical Properties (As Welded)						Available Diameters and Operating Range in Amps						
Yield Strength, ksi		53				3/32"			65 -75			
Tensile Strength, ksi		80				1/8"			80 - 90			
Elongation%, min		30				5/32"			100 - 120			
Welding Positions		F,V,OH,H				3/16"			110 - 130			

b - includes incidental cobalt

d - is 0.12 maximum when specified by purchaser

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