Oxford® ALLOYS, Inc.
Supplier of Welding Alloys

Nickel Alloy Coated Electrodes

Oxford Alloy® 182

SPECIFICATIONS
AWS 5.11
ASME SFA 5.11

CLASSIFICATIONS
AWS ENiCrFe-3
UNS W86182

DESCRIPTION / APPLICATION
Oxford Alloy 182 is used for shielded-metal-arc welding of Inconel® alloys 600, 601, and 690. The weld metal of this electrode has excellent high-temperature strength and oxidation resistance and can meet stringent radiographic requirements. Oxford Alloy 182 is also used in dissimilar welds such as Inconel® alloys and Incoloy® alloys joined to carbon steels, stainless steels, nickel and Monel® alloys; Monel® alloys joined to carbon steels; nickel joined to stainless steels; and stainless steels joined to carbon steels. This electrode can be operated in all welding positions. The power supply is direct current, electrode positive.

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AWS Chemical Composition

Ni	C	Mn	Fe	S	Si	Cu
59.0 min	0.10 max	5.0-9.5	10.0 max	0.015 max	1.0 max	0.50 max
Cr	**Ti**	**Cb+Ta**	**P**	**OET**		
13.0-17.0	1.0 max	1.0-2.5	0.03 max	0.50 max		

TYPICAL MECHANICAL PROPERTIES

Tensile strength:	84,500 psi	580 MPa
Yield strength:	53,500 psi	370 MPa
Elongation:	36%	

Please contact our sales department for more information at 800-562-3355 or 225-273-4800.