



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

Washington Alloy

Ni-182

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



Washington Alloy Ni-182 is a “General Purpose” nickel-chromium-iron flux-coated electrode used for joining many dissimilar combinations of nickel base alloys, of the nickel chromium type, to themselves or to stainless or mild steels. Ni-182 will consistently produce x-ray quality and machinable weld deposits. Excellent for welding Inconel® 600 to itself or to carbon steel and stainless steel; or high chromium Incoloy® 800 to nickel-copper Monel® 400 or nickel base alloy 200. Washington Alloy Ni-182 is used for joining nickel base alloy 200 to stainless steel and nickel-copper Monel® 400 to carbon steel.

Applications

Washington Alloy Ni-182 is very versatile, and can be used for many applications. Common applications include the chemical or petrochemical industries and the nuclear industry where it is used to weld dissimilar joints between vessels and primary piping. Washington Alloy Ni-182 is often used for welding the clad side of nickel-chromium-iron clad steel and for re-surfacing steel.

MECHANICAL PROPERTIES

Tensile Strength (psi)	80,000 min.
Yield Strength (psi)	45,000 min.
Elongation in 2” (%)	30 min.
Avg. Charpy V-notch impact value	60ft.-lbs @ -320°F

TYPICAL WIRE CHEMISTRY (%)

Ni	59.0 min.	Si	1.0 max
Cr	13.0 – 17.0	C	0.10 max
Ti	1.0 max	Mn	5.0-9.5
*Cb	1.0 – 2.5	Fe	10.0 max
Co	0.12 max	S	0.015 max
Others	0.50 max	Cu	0.50 max

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