

NIMROD 182KS

MMA (SMAW)

ALL-POSITIONAL INCONEL™ TYPE MMA ELECTRODE

PRODUCT DESCRIPTION

MMA electrode – This electrode is made on a nearly matching core wire with a basic flux system designed to produce optimum operability and radiographically sound weld metal.

Nimrod 182KS is optimised for DC+ welding in all positions including pipework qualified in the ASME 6G position.

Recovery is about 110% with respect to core wire, 65% with respect to whole electrode.

CLASSIFICATIONS

AWS A5.11M	ENiCrFe-3
ISO 14172	E Ni 6182
APPROVALS	TÜV

ASME IX QUALIFICATION

QW432 F-No 43

WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G



PF/3Gu



PE/4G

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	S	P	Cr	Ni	Nb	Fe	Cu	Ti	Co *	Ta *
min.	--	5.0	--	--	--	13.0	61	1.0	2.0	--	--	--	--
max.	0.10	9.5	1.0	0.015	0.02	17.0	bal	2.5	9.0	0.50	1.0	0.12	0.30
Typical	0.05	7	0.5	0.01	0.01	16	~ 65	1.5	< 8	0.1	0.1	< 0.05	0.05

* Co and Ta maximums only when specified at time of order.

ALL-WELD MECHANICAL PROPERTIES

As-welded	Min.	Typical
Tensile strength [MPa]	550	640
0.2% proof strength [MPa]	360	385
Elongation [%] 4d	30	40
5d	27	37
Reduction of area [%]	--	38
Impact ISO-V(I) -196°C	--	100
Hardness (HV)	--	190

OPERATING PARAMETERS, DC +VE ONLY

Diameter [mm]	2.5	3.2	4.0	5.0
min. A	60	70	100	130
max. A	80	110	155	210

PACKAGING DATA

	Diameter (mm)	Length (mm)	Item number	No of pieces		Weight (kg)	
				can	box	can	box
METAL CAN	2.5	300	NIM182KS-25	235	705	4.2	12.6
	3.2	300	NIM182KS-32	147	441	4.1	12.3
	4.0	350	NIM182KS-40	101	303	5.0	15.0
	5.0	450	NIM182KS-50	70	210	6.7	20.1

Redrying : 200 – 300°C/1-2h to restore to as-packed condition. Maximum 380° C, 3 cycles, 10h total.

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr	Ni	Mo	Cu	F	OES (mg/m³)
2	13	5	10	0.2	0.1	15	1

All information in this data sheet is accurate to the best of our knowledge at the time of printing. Please refer to www.specialalloys.eu for any updated information.