



Characteristics and scope of application

- Filler metal for heat resistant CrNi-steels and Ni-alloys
- Recommended for matching and dissimilar welds of 300 series stainless steels and mild steels
- High impact strength at -321°F

Standard designations

DIN EN ISO 18274	AWS A5.14	DIN Mat.-No.
S Ni 6082 (NiCr20Mn3Nb)	ERNiCr-3	2.4806

Typical chemical composition of filler metal

	C	Si	Mn	Cr	Ni	Nb	Fe
Mass %	0.02	0.15	3.0	19.5	Bal.	2.5	< 0.5

All weld metal properties (min. values at rt)

Heat treatment	Yield strength	Tensile strength	Elongation	Impact toughness	
	Rp0.2	R _m	A ₅	ISO-V	
as welded	58 ksi	90 ksi	35%	150 J	80 J / -321°F

Welding instructions

Polarity	Shielding gas acc. to AWS A5.32
DC / +	SG-A, SG-AHe, SG-A-G (He 30% - H 2% - C ~0.1)
DC / -	SG-A, SG-AHe, SG-AH (max. 5% H ₂ DC / -)

Low heat input and interpass temperature < 248°F. Stringer bead technique recommended.

Base materials
2.4816 – NiCr15Fe – Alloy 600 H – UNS N06600
Austenitic CrNi - steels group 8.1 acc. to ISO 15608
1.5415 – 16Mo3 – ASTM A 672
1.0254 – P235TR1 – ASTM A 106

Packaging (tolerances acc. to AWS A5.02)

Approvals on request

Diameter (in)		lbs/PU
1/16 - 1/8	X 36 in	11 / 22
0.035 – 0.045	BS 300 spool	33
0.06 – 1/8	K 415 / K 435 spool	55