

# TASETO Welding Materials

Ni-Base Alloy Electrodes

For Flux Cored Arc Welding

## GFW82

Applicable Specification  
AWS A5.34 TNi6082-04

### ● Applications and Characteristics

TASETO GFW82 can be applied to welding of wide variety materials, such as welding of nickel alloy 600 (UNS N06600) or nickel alloy 601 (UNS N06601), welding of nickel alloy 800 (UNS N08800), welding of dissimilar metal joint such as nickel alloy to nickel, stainless steel, or to low alloy steel, and welding of stainless steel to low alloy steel in high temperature service. Also it can be applied to welding of clad steel and overlay welding on carbon steel.

### ● Notes on Usage

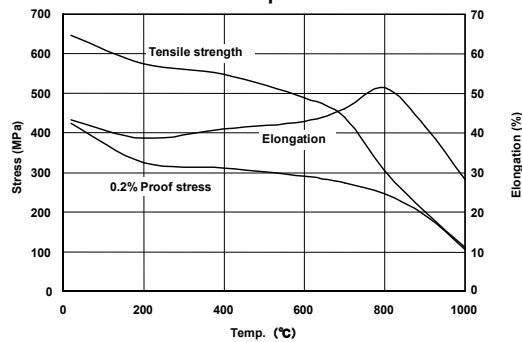
\* To minimize crater crack, fill craters with filler metal and remove crater crack with grinder.

### ● Chemical Composition of All Weld Metal(%)

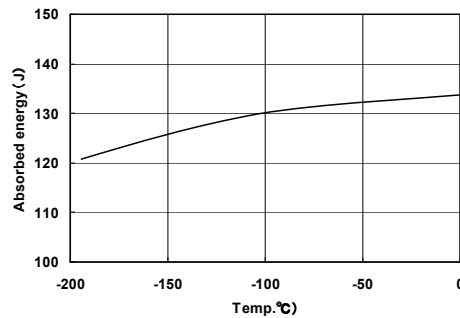
	C	Mn	Fe	P	S	Si	Cu
Typical	0.027	3.08	2.32	0.009	0.001	0.29	Tr.

	Ni	Ti	Cr	Nb+Ta
Typical	69.80	0.49	21.57	2.71

### ● Mechanical Properties of All Weld Metal



Tensile Properties  
at Elevated Temperature



Notch Toughness at Low Temperature  
(2mmV notch)

### ● Sizes Available and Recommended Welding Conditions

Size (mm)	Flat			Horizontal		
	Current (A)	Voltage (V)	Speed (mm/min)	Current (A)	Voltage (V)	Speed (mm/min)
1.2	160~190	26~31	250~350	130~160	25~28	300~400