

**AWS CLASSIFICATION:** A5.34: 2007

ISO: TNi 6082-11/-14 AWS: ENiCr3T1-1/-4

**DESCRIPTION**

Stoody 82-T1 is a gas shielded flux cored wire that can be used for welding in all positions using 100% CO<sub>2</sub> or Argon/CO<sub>2</sub> mixtures. The wire possesses excellent weldability and can be used in a wide variety of similar and dissimilar welding and cladding applications.

**TYPICAL DEPOSIT CHARACTERISTICS**

Tensile Strength	89 ksi (614 MPa)
Yield Strength	58 ksi (400 MPa)
Elongation	26%

**TYPICAL DEPOSIT CHEMISTRY (wt%)**

Carbon	0.04
Manganese	3.0
Silicon	0.4
Chromium	19.0
Iron	1.7
Niobium	2.5
Sulfur	0.003
Phosphorus	0.010
Nickel	Balance

**TYPICAL APPLICATIONS**

Typical applications include:

- Joining nickel-chromium-iron alloys
- Clad side of joints in steels clad with nickel-chromium-iron weld metal
- Surfacing steel with nickel-chromium-iron weld metal
- Joining Inconel 600, 601 and Incoloy 800 to themselves or to stainless and carbon steels.

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

Diameter, in. (mm)	<b>.045 (1.2)</b>
Amperage (DCEP)	150 – 200
Wire Feed Speed (ipm)	290 – 400
Voltage	25 – 26
Shielding Gas	75% Ar -25% Co <sub>2</sub> or 100%CO <sub>2</sub>
Wire Extension, in (mm)	1/2 (12)

Diameter, in. (mm)	<b>1/16 (1.6)</b>
Amperage (DCEP)	200 – 250
Wire Feed Speed (ipm)	190 – 275
Voltage	26 – 27
Shielding Gas	75% Ar -25% Co <sub>2</sub> or 100% CO <sub>2</sub>
Wire Extension, in (mm)	1/2 (12)

**STANDARD SIZES & PACKAGING**

Diameter	Packaging	Part #
.045" (1.2mm)	33# Wire Basket	11872700
1/16" (1.6mm)	33# Wire Basket	11872600

**Stoody Company**

5557 Nashville Road • Bowling Green, KY 42101  
1-800-426-1888

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NOTICE - Failure to follow manufacturer's directions for use may result in equipment or material failure and void any applicable warranty. The data provided or referenced herein is provided for informational purposes only, without guarantee or warranty and represents "typical" results when Stoody products are used in accordance with internal Stoody procedures. Other tests and procedures may produce differing results. Stoody expressly disclaims any liability resulting from reliance on this data.  
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