

NiCro 72M

CATEGORY GMAW-GTAW Solid wires

APPLICATIONS FM 72M is used for the overlay cladding of ferrous materials used in high temperature applications, and the welding of nickel-chromium-iron alloy

CLASSIFICATION

| | |
|--------|------------------------------------|
| AWS | AWS A5.14 ERNiCr-7 (UNS N06073) |
| EN ISO | 18274: S Ni 6073 |
| DIN | 1736: |

APPROVALS CE Approved

WELDING POSITIONS:



TYPICAL CHEMICAL COMPOSITION (%)

| Ni | Cr | Co | Mn | Fe | Si | Mo | Al | Nb+Ta | Others |
|----|-------|-----|------|-----|------|------|-----------|----------|--------|
| 55 | 36-39 | 1.0 | 0.50 | 1.0 | 0.30 | 0.50 | 0.75-1.20 | 0.25-1.0 | 0.50 |

MECHANICAL PROPERTIES (TYPICAL)

| Heat Treatment | Tensile strength | | Elongation (%) |
|----------------|------------------|-----|----------------|
| | (PSI) | MPa | |
| AW | 100 | 690 | 30 |

WELDING PARAMETERS PACKING

| D (mm) | Welding Parameters | Packing (kg) |
|--------|--------------------|--------------|
| | Current (A) DC- | Single |
| 1.14 | | 13.6 |