

## Nicro 92

**CATEGORY** GMAW-GTAW Solid wires

**TYPE** Nickel based Mig / Tig filler metal

**APPLICATIONS** Cladding applications to resist extreme high temperatures and thermal shocks in extreme corrosive environments.

**PROPERTIES** Nicro 92 provides high mechanical strength and corrosion resistance at temperatures ranging from the cryogenic region to over 980°C. The weld deposit can be age hardened for greater strength at temperatures to about 700°C.

**CLASSIFICATION**  
 AWS A 5.14: ER NiCrFe-6  
 UNS: N07092  
 EN ISO 18274: SNI7092 (NiCr15Ti3Mn)

**SUITABLE FOR** Joining Inconel and Incoloy alloys to stainless steels, carbon steels, Monel alloys, joining Monel alloys and Nickel 200 to stainless steels and joining stainless steels to carbon steels. This filler metal can also be used for welding Nickel steels. Excellent for cladding valves and pistons at high working temperature engines.

**WELDING POSITIONS:**



### FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Cr	Ni+Co	Mo	Fe	Cu	Ti
<0.08	2.0-2.7	<0.35	14-17	>67	-	<8	<0.5	2.5-3.5

### MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				-20°C	-40°C	-60°C	
AW		552	30				

AW: as welded

### WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
0.9			D-300	13.6	
1.2			D-300	13.6	

**REDRYING TEMPERATURE** not required

**TIG WELDING** 1000 mm cut lengths are available ranging from 1,6 till 3,2 mm in 5 kg tubes.