

**CATEGORY** GTAW Solid wires

**TYPE** Solid wire for Nickel based high strength alloy 718

**APPLICATIONS** CEWELD NiCro 718 is used in a wide range of applications such as components for liquid fueled rockets, rings, casings and various formed sheet metal parts for aircraft and land-based gas turbine engines, and cryogenic tankage. It is also used for fasteners and instrumentation parts. 718 filler metal can be also used for cladding and overlay of parts in the oil and gas industry.

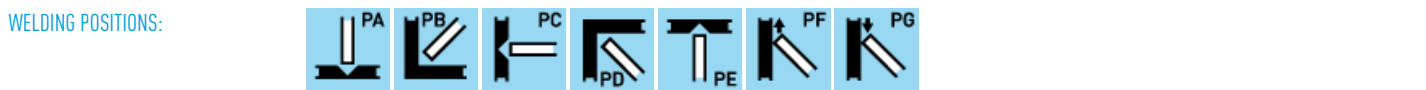
**PROPERTIES** Special alloy with age hardenable deposit and similar mechanical properties as the base metal. Age hardened condition: 720°C for 8 Hours, furnace Cool 55°C/hour to 620°C than Air Cool for 8 hours

**CLASSIFICATION**

AWS	A 5.14: ERNiFeCr-2
EN ISO	18274: S Ni 7718(NiCr19Fe19Nb5Mo3)
F-nr	43
FM	6
W.Nr.	2.4667

**SUITABLE FOR** Inconel 718(2.4668), 706 and X-750 (X750)

**APPROVALS** No Approvals Found



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Cr	Ni	Mo	Nb	Ti	Fe	Al	Nb+Ta
0.06	0.2	0.2	20	53	3	5.1	1	15	0.6	5

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0.2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)
As Welded /	580	860	28

**WELDING PARAMETERS / PACKING**

WELDING PARAMETERS		WELDING PARAMETERS		WELDING PARAMETERS		PACKING		PACKING	
D (MM)	LENGTH (MM)	LENGTH (MM)	CURRENT (A) DC-	KG	KG	KG	KG		
2.4	1000		120-175	5	25				
3.2	1000		150-220	5	25				

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175** I1