


CATEGORY	GMAW Solid wires							
TYPE	Solid nickel base welding wire for Mig (GMAW) welding.							
APPLICATIONS	CEWELD Nicro 52 filler metal is used for welding nickel-chromium-iron (Inconel 690) alloys to themselves, and for dissimilar welding between nickel-chromium-iron alloys and steels or stainless steels. The applications include surfacing as well as clad-side welding. Interpass temperature of 150°C should be respected.							
PROPERTIES	Excellent resistance against oxidizing media combined with high mechanical strength at room temperature but also at extreme high temperatures combined with high ductility due to the high chromium content. Alloy 690 was developed to offer greater resistance to stress corrosion in the nuclear industry, pure water environment.							
CLASSIFICATION	AWS	A 5.14: ERNiCrFe-7						
	EN ISO	18274: S Ni 6052(NiCr30Fe9)						
	F-nr	43						
	FM	6						
	W.Nr.	2.4642						
SUITABLE FOR	Inconel 690, VDM Alloy 690, Microfer 6030 N, FM 52, 2.4642, NiCr29Fe							
APPROVALS	No Approvals Found							
WELDING POSITIONS:								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)								
C	Si	Mn	Cr	Ni	Mo	Nb	Ti	Fe
0.03	0.4	0.8	29.5	60	0.4	0.02	0.5	9
ALL WELD MECHANICAL PROPERTIES								
Heat Treatment	R <sub>p0.2</sub>	R <sub>m</sub>	A5					Hardness
580°C±15°C /1h	MPa	MPa	(%)					Rockwell C
As Welded /	260	580	30					Avg. 200
	770	870	16					
WELDING PARAMETERS / PACKING								
	WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING			
D (MM)	VOLTAGE (V)	CURRENT (A) (DC+)	SPOOL TYPE	KG SPOOL				
0.8	16-26	80-180	KD-300	15				
1.0	16-29	100-250	KD-300	15				
1.2	18-29	125-290	KD-300	15				
REDRYING TEMPERATURE	Not required							
GAS ACCORDING EN 14175	I1							