CEWELD® NiCro 52 Tig

CATEGORY	GTAW Solid wires
TYPE	Solid nickel base welding wire for Tungsten Inert Gas (Tig) 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, Nicrofer 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	Ti	Fe	Al
0.02	0.4	0.8	30	60	0.2	0.5	10	0.3

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Hardness Brinell Hardness
As Welded /	770	870	16	
580°C±15°C /1h	260	580	30	Avg. 200

WELDING PARAMETERS / PACKING

WELDING PARAMETERS D (MM)	WELDING PARAMETERS LENGTH	WELDING PARAMETERS CURRENT (A) (DC-)	PACKING (KG) SINGLE	PACKING (KG) MASTER
1.6	1000	50-80	5	25
2,4	1000	110-180	5	25
3,2	1000	140-280	5	25

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1