


CATEGORY	GTAW Solid wires										
TYPE	Solid nickel base welding wire for Tungsten Inert Gas (TIG) welding										
APPLICATIONS	CEWELD® NiCro 52M Tig 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. This product contains Boron and Zirconium to minimize the tendency for ductility-dip cracking, while it is especially resistant to oxide "floaters" and inclusions.										
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. Similar to FM 52 but the 52M is for nuclear application where a specific (very strict) chemical analysis is requested.										
CLASSIFICATION	AWS	A 5.14: ERNiCrFe-7A									
	EN ISO	18274: S Ni 6054(NiCr29Fe9)									
	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	Al	Nb+Ta	
0.02	0.3	0.7	30	63	0.3	0.8	0.3	10	0.8	0.8	
ALL WELD MECHANICAL PROPERTIES											
Heat Treatment	R _{p0,2}	R _m	A5	Hardness							
	MPa	MPa	(%)	Brinell Hardness							
As Welded /	770	870	16	Avg. 200							
580°C±15°C /1h	260	580	30								
WELDING PARAMETERS / PACKING											
WELDING PARAMETERS	WELDING PARAMETERS		WELDING PARAMETERS		PACKING (KG)		PACKING (KG)				
D (MM)	LENGTH		CURRENT (A) (DC-)		SINGLE		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										