




CEWELD NiCro 72

TYPE	Nickel Chromium solid MIG wire																				
APPLICATIONS	CEWELD® NiCro 72 filler metal is a typical alloy for cladding 671/800HT tubes. Also for overlaying of carbon steels and stainless steels to get a nickel-chromium corrosion resistance surface.																				
PROPERTIES	Due to the high Chromium content it has excellent resistance to high temperature corrosion, also in fuel-ash atmospheres containing sulfur and vanadium																				
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCr-4</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 6072 (NiCr44Ti)</td> </tr> <tr> <td>F-nr</td> <td>46</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.14: ERNiCr-4	EN ISO	18274: S Ni 6072 (NiCr44Ti)	F-nr	46	FM	6												
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EN ISO	18274: S Ni 6072 (NiCr44Ti)																				
F-nr	46																				
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SUITABLE FOR	ASTM B163, B166, B167, B168 with UNS N06690, IN657, Incoloy 671/800H																				
APPROVALS	No Approvals Found																				
WELDING POSITIONS																					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Ti</th> <th>Fe</th> <th>Cu</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.1</td> <td>0.1</td> <td>0.008</td> <td>0.008</td> <td>45</td> <td>55</td> <td>0.6</td> <td>0.2</td> <td>0.2</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Ti	Fe	Cu	0.05	0.1	0.1	0.008	0.008	45	55	0.6	0.2	0.2
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A5 (%)</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td></td> <td>700</td> <td>30</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	As Welded /		700	30												
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As Welded /		700	30																		
REDRYING TEMPERATURE	Not required																				
GAS ACCORDING EN 14175	I1																				



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NICRO 72 1,0MM

Type	KG/unit	EANCode
BS-300	13,60	8720663419088