


# CEWELD NiCro 72M

<b>TYPE</b>	Nickel-Chromium solid MIG wire																		
<b>APPLICATIONS</b>	CEWELD NiCro 72M is used for the overlay cladding of ferrous materials used in high temperature applications, and the welding of nickel-chromium-iron alloy to itself, and to steels. Also for welding IN657 and INCO clad 671/800H.																		
<b>PROPERTIES</b>	Weld metal has good resistance against high temperature oxidation, carburization, sulfidation and to reducing-sulfurizing and metal dusting environments																		
<b>CLASSIFICATION</b>	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCr-7</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 6073(NiCr38AlNbTi)</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.14: ERNiCr-7	EN ISO	18274: S Ni 6073(NiCr38AlNbTi)	F-nr	43	FM	6										
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EN ISO	18274: S Ni 6073(NiCr38AlNbTi)																		
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<b>SUITABLE FOR</b>	ASTM B163, B166, B167, B168 with UNS N06690, IN657, Incoloy 671/800H																		
<b>APPROVALS</b>	No Approvals Found																		
<b>WELDING POSITIONS</b>																			
<b>TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)</b>	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Nb</th> <th>Ti</th> <th>Al</th> <th>Nb+Ta</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.2</td> <td>0.3</td> <td>37</td> <td>65</td> <td>0.8</td> <td>0.6</td> <td>1</td> <td>0.7</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Nb	Ti	Al	Nb+Ta	0.02	0.2	0.3	37	65	0.8	0.6	1	0.7
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<b>ALL WELD MECHANICAL PROPERTIES</b>	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R<sub>p0,2</sub> MPa</th> <th>R<sub>m</sub> MPa</th> <th>A<sub>5</sub> (%)</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td></td> <td>690</td> <td>30</td> </tr> </tbody> </table>	Heat Treatment	R <sub>p0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	As Welded /		690	30										
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<b>REDRYING TEMPERATURE</b>	Not required																		
<b>GAS ACCORDING EN 14175</b>	I1																		



# CEWELD NiCro 72M

NICRO 72M 1,14MM

Type	KG/unit	EANCode
BS-300	13,6	8720663419125