



CEWELD NiCro 52

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, Nicrofer 6030 N, FM 52, 2.4642, NiCr29Fe																																					
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>Cr</th> <th>Ni</th> <th>Mo</th> <th>Nb</th> <th>Ti</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.03</td> <td>0.4</td> <td>0.8</td> <td>29.5</td> <td>60</td> <td>0.4</td> <td>0.02</td> <td>0.5</td> <td>9</td> </tr> </tbody> </table>								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												
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th>R_{p0,2}</th> <th>R_m</th> <th>A₅</th> <th colspan="5">Hardness</th> </tr> <tr> <th>MPa</th> <th>MPa</th> <th>(%)</th> <th colspan="5">Rockwell C</th> </tr> </thead> <tbody> <tr> <td>580°C±15°C /1h</td> <td>260</td> <td>580</td> <td>30</td> <td colspan="5" rowspan="2">Avg. 200</td> </tr> <tr> <td>As Welded /</td> <td>770</td> <td>870</td> <td>16</td> </tr> </tbody> </table>								Heat Treatment	R _{p0,2}	R _m	A ₅	Hardness					MPa	MPa	(%)	Rockwell C					580°C±15°C /1h	260	580	30	Avg. 200					As Welded /	770	870	16
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580°C±15°C /1h	260	580	30	Avg. 200																																		
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REDRYING TEMPERATURE	Not required																																					
GAS ACCORDING EN 14175	I1																																					



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NICRO 52 1,14MM

Type	KG/unit	EANCode
BS-300	15	8720663418234