CEWELD NiCro 52 Tig

certilas® THE FILLER METAL SPECIALIST

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

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

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CEWELD NiCro 52 Tig

NICRO 52 TIG 1,6 X 914MM	Type	KG/unit	EANCode
	Tube	4,54	8720663418241

NICRO 52 TIG 2,4 X 1000MM	Type	KG/unit	EANCode
	Tube	4,54	8720663418265