CEWELD Nicro FM 53MD Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Nickel based filler metal against extreme temperature conditions.

APPLICATIONS

CEWELD NiCro FM 53MD is used for the gas-tungsten-arc and gas-metal-arc welding of INCONEL alloy 693, and the overlaying of carbon steels and stainless steels to provide a nickel-chromium-aluminum alloy corrosion resistant surface.

PROPERTIES

Excellent welding properties with high build-up capacity and low dilution rate. Excellent resistance against temperature cycling conditions exceeding 1200°C and carburized medias. Excellent fatigue strength and creep properties. The high chromium and aluminum levels provide excellent resistance to metal dusting in chemical and petrochemical applications. The product also provides excellent resistance to carburization, sulfidation, and other high temperature corrosion forms Welding similar alloys that have to resist extreme high temperature and for cladding steels or stainless steels to obtain a high temperature resistant surface against oxidation.

CLASSIFICATION

AWS	A 5.14: ERNiCrFeAl-1
EN ISO	18274: S Ni 6693(NiCr29Fe4Al3)
F-nr	43
FM	6

SUITABLE FOR

Cladding against high temperature, radiant heater tubes, furnace rolls, muffles in bright annealing furnaces (H2 atmosphere), rotary kilns, pipe hangers, waste gas components, hydrogen production, methanol and ammonia synthesis, Inconel alloy 693

APPROVALS

CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Nb	Fe	Al	Nb+Ta
0.1	0.4	0.8	30	60	2	4	3.5	2

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded		760	45	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175

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NICRO FM 53MD TIG 2,4 X 914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663418289