



# CEWELD NiCrCo 5828

**TYPE** Welding wire for Waspaloy and similar precipitation hardening, high temperature Nickel based alloys.l

**APPLICATIONS** CEWELD NiCrCo 5828 is a high temperature alloy, which is used for welding nickel-chromium-cobalt-molybdenum alloys (UNS Number N07001). Main applications are Gas turbine engine parts, Aerospace components, springs and fasteners.

**PROPERTIES** Very high strength properties at elevated temperatures, Strength is generally comparable to that of Rene 41 and generally superior to Inconel 718. Age hardenable while maintaining excellent high-temperature strength and good corrosion resistance, notably to oxidation, at service temperatures ranging from 1200°F (650°C) up to 1600°F (870°C)

**CLASSIFICATION**

AWS	A 5.14: ERNiCrCoMo-2 mod
EN ISO	18274: S NiZCr20Co14Mo4Ti3
W.Nr.	2.4654
F-nr	43
FM	6

**SUITABLE FOR** AMS 5708, 5709, 5706, 5707, 5704, 5544, 5586.  
PWA 1005, 1007, 1016, 1027.  
ASTM B637.

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Cr	Ni	Mo	Ti	Co
0.06	0.05	0.05	20	58	4	3	14

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
760°C±15°C 10h	1000	1400	14	40 HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1