



# CEWELD NiCro 92 Tig

<b>TYPE</b>	Nickel based Mig / Tig filler metal														
<b>APPLICATIONS</b>	Cladding applications to resist extreme high temperatures and thermal shocks in extreme corrosive environments.														
<b>PROPRIÉTÉS</b>	CEWELD NiCro 92 provides high mechanical strength and corrosion resistance at temperatures ranging from the cryogenic region to over 980°C. The weld deposit can be age hardened for greater strength at temperatures to about 700°C.														
<b>CLASSIFICATION</b>	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCrFe-6</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 7092(NiCr15Ti3Mn)</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.14: ERNiCrFe-6	EN ISO	18274: S Ni 7092(NiCr15Ti3Mn)	F-nr	43	FM	6						
AWS	A 5.14: ERNiCrFe-6														
EN ISO	18274: S Ni 7092(NiCr15Ti3Mn)														
F-nr	43														
FM	6														
<b>CONVIENT POUR</b>	Joining Inconel and Incoloy alloys to stainless steels, carbon steels, Monel alloys, joining Monel alloys and Nickel 200 to stainless steels and joining stainless steels to carbon steels. This filler metal can also be used for welding Nickel steels. Excellent for cladding valves and pistons at high working temperature engines.														
<b>AGRÉMENTS</b>															
<b>POSITIONS DE SOUDAGE</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>Ti</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.06</td> <td>0.2</td> <td>2.5</td> <td>16</td> <td>70</td> <td>3</td> <td>6</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Ti	Fe	0.06	0.2	2.5	16	70	3	6
C	Si	Mn	Cr	Ni	Ti	Fe									
0.06	0.2	2.5	16	70	3	6									
<b>PROPRIÉTÉS MÉCANIQUES</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> <th>Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td></td> <td>552</td> <td>30</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness	As Welded		552	30	HRc				
Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness											
As Welded		552	30	HRc											
<b>ETUVAGE</b>	Not required														
<b>GAS ACC. EN ISO 14175</b>	I1														