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,

PROPRIÉTÉS

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)
W.Nr.	2.4642
F-nr	43
FM	6

CONVIENT POUR

Inconel 690, VDM Alloy 690, Nicrofer 6030 N, FM 52, 2.4642, NiCr29Fe

AGRÉMENTS

POSITIONS DE SOUDAGE

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

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	770	870	16	HRc
580°C±15°C 1h	260	580	30	200 HB

ETUVAGE

Not required

GAS ACC. EN ISO 14175

I1

CEWELD NiCro 52 Tig

certilas® THE FILLER METAL SPECIALIST

NICRO 52 TIG 1,6 X 914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663418241

NICRO 52 TIG 2,4 X 1000MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663418265