



CEWELD NiCro 72M

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|-----------------------|--|-----|------------------|--------|--------------------------------|------|----|----|---|
| TYPE | Nickel-Chromium solid MIG wire | | | | | | | | |
| ANWENDUNGEN | CEWELD NiCro 72M is used for the overlay cladding of ferrous materials used in high temperature applications, and the welding of nickel-chromium-iron alloy to itself, and to steels. Also for welding IN657 and INCO clad 671/800H. | | | | | | | | |
| EIGENSCHAFTEN | Weld metal has good resistance against high temperature oxidation, carburization, sulfidation and to reducing-sulfurizing and metal dusting environments | | | | | | | | |
| KLASSIFIKATION | <table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCr-7</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 6073(NiCr38AlNbTi)</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table> | AWS | A 5.14: ERNiCr-7 | EN ISO | 18274: S Ni 6073(NiCr38AlNbTi) | F-nr | 43 | FM | 6 |
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GEEIGNET FÜR ASTM B163, B166, B167, B168 with UNS N06690, IN657, Incoloy 671/800H

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Si | Mn | Cr | Ni | Nb | Ti | Al | Nb+Ta |
|------|-----|-----|----|----|-----|-----|----|-------|
| 0.02 | 0.2 | 0.3 | 37 | 65 | 0.8 | 0.6 | 1 | 0.7 |

MECHANISCHE GÜTEWERTE

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded | | 690 | 30 | HRc |

RÜCKTROCKNUNG Not required

GAS ACC. EN ISO 14175 11



CEWELD NiCro 72M

NICRO 72M 1,14MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 13,6 | 8720663419125 |