





TYPE Solid nickel base welding wire for Mig (GMAW) 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,

PROPERTIES 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

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

**APPROVALS** 

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

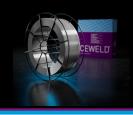
MECHANICAL PROPERTIES

С	Si	Mn	Cr	Ni	Мо	Nb	Ti	Fe
0.03	0.4	0.8	29.5	60	0.4	0.02	0.5	9

Heat Treatment	R <sub>P0,2</sub> (MPa)	Rm (MPa)	A5 (%)	Hardness
580°C±15°C 1h	260	580	30	200 HB
As Welded	770	870	16	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 | 11





## **CEWELD NiCro 52**

NICRO 52 1,14MM

Packaging	KG/unit	EanCode		
BS-300	15	8720663418234		