



# CEWELD NiCro 718

**TYPE** Solid wire for Nickel based high strength alloy 718

**APPLICATIONS** CEWELD® NiCro 718 is used in a wide range of applications such as components for liquid fueled rockets, rings, casings and various formed sheet metal parts for aircraft and land-based gas turbine engines, and cryogenic tankage. It is also used for fasteners and instrumentation parts. 718 filler metal can be also used for cladding and overlay of parts in the oil and gas industry.

**PROPERTIES** Special alloy with age hardenable deposit and similar mechanical properties as the base metal. Age hardened condition: 720°C for 8 Hours, furnace Cool 55°C/ hour to 620°C, than Air Cool for 8 hours.

**CLASSIFICATION**

AWS	A 5.14: ERNiFeCr-2
EN ISO	18274: S Ni 7718(NiCr19Fe19Nb5Mo3)
W.Nr.	2.4667
F-nr	43
FM	6

**SUITABLE FOR** Cr-Ni-Nb-Mo alloy and 718, 706, and X-750 alloys.  
**EN W.Nr.:** 2.4668 (NiCr19Fe19Nb5Mo3), 2.4669 (NiCr15Fe7TiAl).  
**ASTM:** B637, 5589.  
**UNS:** N07718, N09706, N07750.  
 Inconel 718(2.4668), 706 and X-750 (X750)

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Cr	Ni	Mo	Nb	Ti	Fe	Al	Nb+Ta	PREN
0.06	0.2	0.2	20	53	3	5.1	1	20	0.6	5	27

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	580	860	28	HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** 11



# CEWELD NiCro 718

NICRO 718 1,14MM

Packaging	KG/unit	EanCode
BS-300	13,6	8720663418982

NICRO 718 1,2MM

Packaging	KG/unit	EanCode
BS-300	12,70	8720663418968
BS-300	15	8720663418975

NICRO 718 1,6MM

Packaging	KG/unit	EanCode
BS-300	13,6	8720663418999