



# CEWELD NiCrCo 282

|                                                   |                                                                                                                                                                                                                                                                                                                                                         |                            |     |                         |                      |        |          |    |     |
|---------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|-----|-------------------------|----------------------|--------|----------|----|-----|
| TYPE                                              | Nickel based Solid wire, HAYNES 282-Typ (NiCrCoMo) , precipitation hardening, high temperature alloy used for welding similar to composition base alloys.                                                                                                                                                                                               |                            |     |                         |                      |        |          |    |     |
| APPLICATIONS                                      | CEWELD NiCrCo 282 is a high temperature alloy which is used for welding of nickel-chromium-cobalt-molybdenum alloys (UNS Number N07208). This filler metal can also be used for suitable for critical gas turbine applications found in the combustors, turbine and exhaust sections, and nozzle components, Aerospace components,Springs and fasteners |                            |     |                         |                      |        |          |    |     |
| PROPERTIES                                        | Very high strength at elevated temperatures Strength is generally comparable or surpassing Waspaloy and approaching R-41 and Alloy 263 hardenable High temperature dynamic applications                                                                                                                                                                 |                            |     |                         |                      |        |          |    |     |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                     | A 5.14: ERNiCrCoMo-2 mod   |     |                         |                      |        |          |    |     |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                  | 18274: S NiZCr20Co10Mo8Ti3 |     |                         |                      |        |          |    |     |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                    | 43                         |     |                         |                      |        |          |    |     |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                      | 6                          |     |                         |                      |        |          |    |     |
| SUITABLE FOR                                      | HAYNES® 282® alloy, UNS N07208, SAE AMS 5951 / 5915, ASTM B637                                                                                                                                                                                                                                                                                          |                            |     |                         |                      |        |          |    |     |
| APPROVALS                                         |                                                                                                                                                                                                                                                                                                                                                         |                            |     |                         |                      |        |          |    |     |
| WELDING POSITIONS                                 |                                                                                                                                                                                                                                                                        |                            |     |                         |                      |        |          |    |     |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                       | Si                         | Mn  | Cr                      | Ni                   | Mo     | Ti       | Co | Al  |
|                                                   | 0.06                                                                                                                                                                                                                                                                                                                                                    | 0.15                       | 0.3 | 20                      | 57                   | 8.5    | 2.1      | 10 | 1.5 |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                                                                                                                                                                                          |                            |     | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |    |     |
|                                                   | 760°C±15°C 10h                                                                                                                                                                                                                                                                                                                                          |                            |     | 1100                    | 1450                 | 28     | 40 HRc   |    |     |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                            |                            |     |                         |                      |        |          |    |     |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                      |                            |     |                         |                      |        |          |    |     |