



# CEWELD NiCro 72

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                             |     |                            |       |                         |    |           |          |     |
|------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|-----|----------------------------|-------|-------------------------|----|-----------|----------|-----|
| TYPE                                                 | Nickel Chromium solid MIG wire                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                             |     |                            |       |                         |    |           |          |     |
| APPLICATIONS                                         | CEWELD® NiCro 72 filler metal is a typical alloy for cladding 671/800HT tubes. Also for overlaying of carbon steels and stainless steels to get a nickel-chromium corrosion resistance surface.                                                                                                                                                                                                                                                                                                                        |                             |     |                            |       |                         |    |           |          |     |
| PROPRIÉTÉS                                           | Due to the high Chromium content it has excellent resistance to high temperature corrosion, also in fuel-ash atmospheres containing sulfur and vanadium                                                                                                                                                                                                                                                                                                                                                                |                             |     |                            |       |                         |    |           |          |     |
| CLASSIFICATION                                       | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | A 5.14: ERNiCr-4            |     |                            |       |                         |    |           |          |     |
|                                                      | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 18274: S Ni 6072 (NiCr44Ti) |     |                            |       |                         |    |           |          |     |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 46                          |     |                            |       |                         |    |           |          |     |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 6                           |     |                            |       |                         |    |           |          |     |
| CONVIENT POUR                                        | ASTM B163, B166, B167, B168 with UNS N06690, IN657, Incoloy 671/800H                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                             |     |                            |       |                         |    |           |          |     |
| AGRÉMENTS                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                             |     |                            |       |                         |    |           |          |     |
| POSITIONS DE SOUDAGE                                 | <div>     </div> |                             |     |                            |       |                         |    |           |          |     |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Si                          | Mn  | P                          | S     | Cr                      | Ni | Ti        | Fe       | Cu  |
|                                                      | 0.05                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 0.1                         | 0.1 | 0.008                      | 0.008 | 45                      | 55 | 0.6       | 0.2      | 0.2 |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                             |     | R <sub>P0,2</sub><br>(MPa) |       | R <sub>m</sub><br>(MPa) |    | A5<br>(%) | Hardness |     |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                             |     |                            |       | 700                     |    | 30        | HRc      |     |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                             |     |                            |       |                         |    |           |          |     |
| GAS ACC. EN ISO 14175                                | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                             |     |                            |       |                         |    |           |          |     |



# CEWELD NiCro 72

NICRO 72 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 13,60   | 8720663419088 |