



CEWELD NiCr 52

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 (%)	C	Si	Mn	Cr	Ni	Mo	Nb	Ti	Fe
	0.03	0.4	0.8	29.5	60	0.4	0.02	0.5	9
MECHANICAL PROPERTIES	Heat Treatment			R _{P0,2} (MPa)	R _m (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	I1								



CEWELD NiCro 52

NICRO 52 1,14MM

Packaging	KG/unit	EanCode
BS-300	15	8720663418234