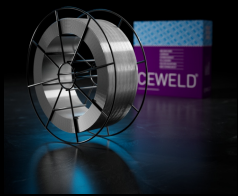


# CEWELD NiCro 72M

|                                                      |                                                                                                                                                                                                                                      |                                |     |                            |                         |           |          |    |       |
|------------------------------------------------------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------|-----|----------------------------|-------------------------|-----------|----------|----|-------|
| TYPE                                                 | Nickel-Chromium solid MIG wire                                                                                                                                                                                                       |                                |     |                            |                         |           |          |    |       |
| APPLICATIONS                                         | CEWELD NiCro 72M is used for the overlay cladding of ferrous materials used in high temperature applications, and the welding of nickel-chromium-iron alloy to itself, and to steels. Also for welding IN657 and INCO clad 671/800H. |                                |     |                            |                         |           |          |    |       |
| PROPRIÉTÉS                                           | Weld metal has good resistance against high temperature oxidation, carburization, sulfidation and to reducing-sulfurizing and metal dusting environments                                                                             |                                |     |                            |                         |           |          |    |       |
| CLASSIFICATION                                       | AWS                                                                                                                                                                                                                                  | A 5.14: ERNiCr-7               |     |                            |                         |           |          |    |       |
|                                                      | EN ISO                                                                                                                                                                                                                               | 18274: S Ni 6073(NiCr38AlNbTi) |     |                            |                         |           |          |    |       |
|                                                      | F-nr                                                                                                                                                                                                                                 | 43                             |     |                            |                         |           |          |    |       |
|                                                      | FM                                                                                                                                                                                                                                   | 6                              |     |                            |                         |           |          |    |       |
| CONVIENT POUR                                        | ASTM B163, B166, B167, B168 with UNS N06690, IN657, Incoloy 671/800H                                                                                                                                                                 |                                |     |                            |                         |           |          |    |       |
| AGRÉMENTS                                            |                                                                                                                                                                                                                                      |                                |     |                            |                         |           |          |    |       |
| POSITIONS DE SOUDAGE                                 |                                                                                                                                                     |                                |     |                            |                         |           |          |    |       |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                    | Si                             | Mn  | Cr                         | Ni                      | Nb        | Ti       | Al | Nb+Ta |
|                                                      | 0.02                                                                                                                                                                                                                                 | 0.2                            | 0.3 | 37                         | 65                      | 0.8       | 0.6      | 1  | 0.7   |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                       |                                |     | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A5<br>(%) | Hardness |    |       |
|                                                      | As Welded                                                                                                                                                                                                                            |                                |     |                            | 690                     | 30        | HRc      |    |       |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                         |                                |     |                            |                         |           |          |    |       |
| GAS ACC. EN ISO 14175                                | I1                                                                                                                                                                                                                                   |                                |     |                            |                         |           |          |    |       |



# CEWELD NiCro 72M

NICRO 72M 1,14MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 13,6    | 8720663419125 |