

# CEWELD NiCro 52

**TYPE** Solid nickel base welding wire for Mig (GMAW) welding.

**ANWENDUNGEN** 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,

**EIGENSCHAFTEN** 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..

**KLASSIFIKATION**

|        |                             |
|--------|-----------------------------|
| AWS    | A 5.14: ERNiCrFe-7          |
| EN ISO | 18274: S Ni 6052(NiCr30Fe9) |
| W.Nr.  | 2.4642                      |
| F-nr   | 43                          |
| FM     | 6                           |

**GEEIGNET FÜR** Inconel 690, VDM Alloy 690, Nicrofer 6030 N, FM 52, 2.4642, NiCr29Fe

**ZULASSUNGEN**

**SCHWEISSPOSITIONEN**



**TYPISCHE CHEMISCHE  
ANALYSE DES  
FÜLLMETALLS (%)**

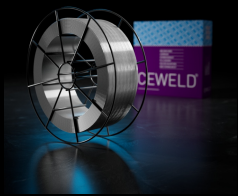
| C    | Si  | Mn  | Cr   | Ni | Mo  | Nb   | Ti  | Fe |
|------|-----|-----|------|----|-----|------|-----|----|
| 0.03 | 0.4 | 0.8 | 29.5 | 60 | 0.4 | 0.02 | 0.5 | 9  |

**MECHANISCHE GÜTEWERTE**

| Heat Treatment | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Hardness |
|----------------|----------------------------|-------------------------|-----------------------|----------|
| 580°C±15°C 1h  | 260                        | 580                     | 30                    | 200 HB   |
| As Welded      | 770                        | 870                     | 16                    | HRc      |

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD NiCro 52

NICRO 52 1,14MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 15      | 8720663418234 |