



CEWELD NiCro 72M

TYPE Nickel-Chromium solid MIG wire

APPLICATIONS **CEWELD® NiCro 72M** is used for overlay cladding on ferrous materials in high-temperature applications, as well as for joining nickel-chromium-iron alloys to themselves and to carbon or stainless steels.
It is specifically designed for automated waterwall cladding, protecting high-wear areas (such as soot-blower lanes and nose-tile deflector areas), and servicing boiler systems operating under low-NO₂ combustion conditions.

PROPERTIES **CEWELD® NiCro 72M** is a metallurgically modified FM 72 solid wire. By fine-tuning the alloying elements, the fluidity of the weld pool is significantly improved, reducing the risk of solidification cracking during automated GMAW (MIG) or GTAW (TIG) overlay welding on boiler waterwalls. The weld metal provides excellent resistance to high-temperature oxidation, carburization, and sulfidation, as well as superior performance in reducing-sulfidizing and metal dusting environments.

CLASSIFICATION

AWS	A 5.14: ERNiCr-7
EN ISO	18274: S Ni 6073(NiCr38AlNbTi)
F-nr	43
FM	6

SUITABLE FOR ASTM B163, B166, B167, B168 with UNS N06690, IN657, Incoloy 671/800H

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

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

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded		690	30	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD NiCro 72M

NICRO 72M 1,14MM

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