



# CEWELD NiCro 92 Tig

|                                                      |                                                                                                                                                                                                                                                                                                                                          |                               |                            |                         |                       |          |    |
|------------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------|----------------------------|-------------------------|-----------------------|----------|----|
| TYPE                                                 | Nickel based Mig / Tig filler metal                                                                                                                                                                                                                                                                                                      |                               |                            |                         |                       |          |    |
| APPLICATIONS                                         | Cladding applications to resist extreme high temperatures and thermal shocks in extreme corrosive environments.                                                                                                                                                                                                                          |                               |                            |                         |                       |          |    |
| PROPRIÉTÉS                                           | CEWELD NiCro 92 provides high mechanical strength and corrosion resistance at temperatures ranging from the cryogenic region to over 980°C. The weld deposit can be age hardened for greater strength at temperatures to about 700°C.                                                                                                    |                               |                            |                         |                       |          |    |
| CLASSIFICATION                                       | AWS                                                                                                                                                                                                                                                                                                                                      | A 5.14: ERNiCrFe-6            |                            |                         |                       |          |    |
|                                                      | EN ISO                                                                                                                                                                                                                                                                                                                                   | 18274: S Ni 7092(NiCr15Ti3Mn) |                            |                         |                       |          |    |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                     | 43                            |                            |                         |                       |          |    |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                       | 6                             |                            |                         |                       |          |    |
| CONVIENT POUR                                        | Joining Inconel and Incoloy alloys to stainless steels, carbon steels, Monel alloys, joining Monel alloys and Nickel 200 to stainless steels and joining stainless steels to carbon steels. This filler metal can also be used for welding Nickel steels. Excellent for cladding valves and pistons at high working temperature engines. |                               |                            |                         |                       |          |    |
| AGRÉMENTS                                            |                                                                                                                                                                                                                                                                                                                                          |                               |                            |                         |                       |          |    |
| POSITIONS DE SOUDAGE                                 |                                                                                                                                                                                                                                                         |                               |                            |                         |                       |          |    |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                        | Si                            | Mn                         | Cr                      | Ni                    | Ti       | Fe |
|                                                      | 0.06                                                                                                                                                                                                                                                                                                                                     | 0.2                           | 2.5                        | 16                      | 70                    | 3        | 6  |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                                                                                                                           |                               | R <sub>P0,2</sub><br>(MPa) | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Hardness |    |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                |                               |                            | 552                     | 30                    | HRc      |    |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                             |                               |                            |                         |                       |          |    |
| GAS ACC. EN ISO 14175                                | I1                                                                                                                                                                                                                                                                                                                                       |                               |                            |                         |                       |          |    |