CEWELD NiCro 52M Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid nickel base welding wire for Tungsten Inert Gas (TIG) welding

APPLICATIONS

CEWELD® Nicro 52M Tig 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. This product contains Boron and Zirconium to minimize the tendency for ductility-dip cracking, while it is especially resistant to oxide "floaters" and inclusions.

PROPRIÉTÉS

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. Similar to FM 52 but the 52M is for nuclear application where a specific (very strict) chemical analysis is requested.

CLASSIFICATION

AWS	A 5.14: ERNiCrFe-7A
EN ISO	18274: S Ni 6054(NiCr29Fe9)
W.Nr.	2.4642
F-nr	43
FM	6

CONVIENT POUR

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

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL D'APPORT (%)

C	Si	Mn	Cr	Ni	Mo	Nb	Ti	Fe	Al	Nb+Ta
0.02	0.3	0.7	30	63	0.3	0.8	0.3	10	0.8	0.8

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	770	870	16	HRc
580°C±15°C 1h	260	580	30	200 HB

ETUVAGE

Not required

GAS ACC. EN ISO 14175

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NICRO 52M TIG 2,4 X 914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663418272

NICRO 52M TIG 3,2 X 914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663418258