



# CEWELD NiCro 72

|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                             |     |                         |       |                      |    |        |          |     |
|------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|-----|-------------------------|-------|----------------------|----|--------|----------|-----|
| TYPE                                           | Nickel Chromium solid MIG wire                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                             |     |                         |       |                      |    |        |          |     |
| ANWENDUNGEN                                    | CEWELD® NiCro 72 filler metal is a typical alloy for cladding 671/800HT tubes. Also for overlaying of carbon steels and stainless steels to get a nickel-chromium corrosion resistance surface.                                                                                                                                                                                                                                                                                                                        |                             |     |                         |       |                      |    |        |          |     |
| EIGENSCHAFTEN                                  | Due to the high Chromium content it has excellent resistance to high temperature corrosion, also in fuel-ash atmospheres containing sulfur and vanadium                                                                                                                                                                                                                                                                                                                                                                |                             |     |                         |       |                      |    |        |          |     |
| KLASSIFIKATION                                 | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | A 5.14: ERNiCr-4            |     |                         |       |                      |    |        |          |     |
|                                                | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 18274: S Ni 6072 (NiCr44Ti) |     |                         |       |                      |    |        |          |     |
|                                                | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 46                          |     |                         |       |                      |    |        |          |     |
|                                                | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 6                           |     |                         |       |                      |    |        |          |     |
| GEEIGNET FÜR                                   | ASTM B163, B166, B167, B168 with UNS N06690, IN657, Incoloy 671/800H                                                                                                                                                                                                                                                                                                                                                                                                                                                   |                             |     |                         |       |                      |    |        |          |     |
| ZULASSUNGEN                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                             |     |                         |       |                      |    |        |          |     |
| SCHWEISSPOSITIONEN                             | <div>     </div> |                             |     |                         |       |                      |    |        |          |     |
| TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Si                          | Mn  | P                       | S     | Cr                   | Ni | Ti     | Fe       | Cu  |
|                                                | 0.05                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 0.1                         | 0.1 | 0.008                   | 0.008 | 45                   | 55 | 0.6    | 0.2      | 0.2 |
| MECHANISCHE GÜTEWERTE                          | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                             |     | R <sub>P0,2</sub> (MPa) |       | R <sub>m</sub> (MPa) |    | A5 (%) | Hardness |     |
|                                                | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                             |     |                         |       | 700                  |    | 30     | HRc      |     |
| RÜCKTROCKNUNG                                  | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                             |     |                         |       |                      |    |        |          |     |
| GAS ACC. EN ISO 14175                          | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                             |     |                         |       |                      |    |        |          |     |



# CEWELD NiCro 72

NICRO 72 1,0MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 13,60   | 8720663419088 |