



# CEWELD NiCro 72 Tig

|                                                   |                                                                                                                                                                                         |                             |                         |                      |        |          |     |
|---------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-----------------------------|-------------------------|----------------------|--------|----------|-----|
| TYPE                                              | Nickel Chromium TIG rods                                                                                                                                                                |                             |                         |                      |        |          |     |
| APPLICATIONS                                      | 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. |                             |                         |                      |        |          |     |
| PROPERTIES                                        | Due to the high Chromium content it has excellent resistance to high temperature corrosion, also in fuel-ash atmosphere containing sulfur and vanadium                                  |                             |                         |                      |        |          |     |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                     | A 5.14: ERNiCr-4            |                         |                      |        |          |     |
|                                                   | EN ISO                                                                                                                                                                                  | 18274: S Ni 6072 (NiCr44Ti) |                         |                      |        |          |     |
|                                                   | 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     | Ti       | Fe  |
|                                                   | 0.08                                                                                                                                                                                    | 0.1                         | 0.1                     | 43                   | 55     | 0.7      | 0.2 |
| MECHANICAL PROPERTIES                             | Heat Treatment                                                                                                                                                                          |                             | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |     |
|                                                   | As Welded                                                                                                                                                                               |                             |                         | 690                  | 30     | HRc      |     |
| REDRYING                                          | Not required                                                                                                                                                                            |                             |                         |                      |        |          |     |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                      |                             |                         |                      |        |          |     |



# CEWELD NiCro 72 Tig

NICRO 72 TIG 1,6 X 914MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 4,54    | 8720663419101 |

NICRO 72 TIG 2,4 X 914MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 4,54    | 8720663419118 |