
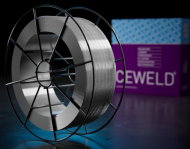




CEWELD NiCro 72M

TYPE	Nickel-Chromium solid MIG wire																		
ANWENDUNGEN	CEWELD NiCro 72M is used for the overlay cladding of ferrous materials used in high temperature applications, and the welding of nickel-chromium-iron alloy to itself, and to steels. Also for welding IN657 and INCO clad 671/800H.																		
EIGENSCHAFTEN	Weld metal has good resistance against high temperature oxidation, carburization, sulfidation and to reducing-sulfurizing and metal dusting environments																		
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCr-7</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 6073(NiCr38AlNbTi)</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.14: ERNiCr-7	EN ISO	18274: S Ni 6073(NiCr38AlNbTi)	F-nr	43	FM	6										
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EN ISO	18274: S Ni 6073(NiCr38AlNbTi)																		
F-nr	43																		
FM	6																		
GEEIGNET FÜR	ASTM B163, B166, B167, B168 with UNS N06690, IN657, Incoloy 671/800H																		
ZULASSUNGEN																			
SCHWEISSPOSITIONEN																			
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Nb</th> <th>Ti</th> <th>Al</th> <th>Nb+Ta</th> </tr> </thead> <tbody> <tr> <td>0.02</td> <td>0.2</td> <td>0.3</td> <td>37</td> <td>65</td> <td>0.8</td> <td>0.6</td> <td>1</td> <td>0.7</td> </tr> </tbody> </table>	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
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MECHANISCHE GÜTEWERTE	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>Heat Treatment</th> <th>R_{P0,2} (MPa)</th> <th>R_m (MPa)</th> <th>A5 (%)</th> <th>Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td></td> <td>690</td> <td>30</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Hardness	As Welded		690	30	HRc								
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As Welded		690	30	HRc															
RÜCKTROCKNUNG	Not required																		
GAS ACC. EN ISO 14175	I1																		



CEWELD NiCro 72M

NICRO 72M 1,14MM

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