



CEWELD NiCro 52M Tig

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.

PROPERTIES 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

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

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

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

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	770	870	16	HRC
580°C±15°C 1h	260	580	30	200 HB

REDRYING Not required

GAS ACC. EN ISO 14175 I1



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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