



CEWELD NiCr 52 Tig

TYPE Solid nickel base welding wire for Tungsten Inert Gas (Tig) welding.

TOEPASSINGEN CEWELD Nicro 52 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. Interpass temperature of 150°C should be respected,

EIGENSCHAPPEN 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..

CLASSIFICATIE

| | |
|--------|-----------------------------|
| AWS | A 5.14: ERNiCrFe-7 |
| EN ISO | 18274: S Ni 6052(NiCr30Fe9) |
| W.Nr. | 2.4642 |
| F-nr | 43 |
| FM | 6 |

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

GOEDKEURINGEN

LASPOSITIES



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

| C | Si | Mn | Cr | Ni | Mo | Ti | Fe | Al |
|------|-----|-----|----|----|-----|-----|----|-----|
| 0.02 | 0.4 | 0.8 | 30 | 60 | 0.2 | 0.5 | 10 | 0.3 |

MECHANISCHE WAARDEN

| 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 |

HERDROGEN Not required

GAS ACC. EN ISO 14175 I1



CEWELD NiCro 52 Tig

NICRO 52 TIG 1,6 X 914MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Tube | 4,54 | 8720663418241 |

NICRO 52 TIG 2,4 X 1000MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| Tube | 4,54 | 8720663418265 |