



# CEWELD NiCro 72M

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                |     |                         |                      |        |          |    |       |
|---------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------|-----|-------------------------|----------------------|--------|----------|----|-------|
| TYPE                                              | Nickel-Chromium solid MIG wire                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                |     |                         |                      |        |          |    |       |
| TOEPASSINGEN                                      | 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.                                                                                                                                                                                                                                                                                                                                                                     |                                |     |                         |                      |        |          |    |       |
| EIGENSCHAPPEN                                     | Weld metal has good resistance against high temperature oxidation, carburization, sulfidation and to reducing-sulfurizing and metal dusting environments                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                |     |                         |                      |        |          |    |       |
| CLASSIFICATIE                                     | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | A 5.14: ERNiCr-7               |     |                         |                      |        |          |    |       |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 18274: S Ni 6073(NiCr38AlNbTi) |     |                         |                      |        |          |    |       |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 43                             |     |                         |                      |        |          |    |       |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | 6                              |     |                         |                      |        |          |    |       |
| GESCHIKT VOOR                                     | ASTM B163, B166, B167, B168 with UNS N06690, IN657, Incoloy 671/800H                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                |     |                         |                      |        |          |    |       |
| GOEDKEURINGEN                                     |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                |     |                         |                      |        |          |    |       |
| LASPOSITIES                                       | <div>      </div> |                                |     |                         |                      |        |          |    |       |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | 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   |
| MECHANISCHE WAARDEN                               | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                |     | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) | A5 (%) | Hardness |    |       |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                |     |                         | 690                  | 30     | HRc      |    |       |
| HERDROGEN                                         | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                |     |                         |                      |        |          |    |       |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                |     |                         |                      |        |          |    |       |



# CEWELD NiCro 72M

NICRO 72M 1,14MM

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