

## INCONEL® Filler Metal 52

**INCONEL Filler Metal 52** is used for gas-tungsten-arc and gas-metal welding of INCONEL alloy 690. This NiCrFe welding product was developed to meet the changing needs of the nuclear industry, the higher chromium level providing greater resistance to stress-corrosion cracking in the nuclear, pure water environment. INCONEL Filler Metal 52 produces corrosion-resistant overlays on most low-alloy and stainless steels. It can also be used in applications requiring resistance to oxidizing acids. It is useful for dissimilar joints involving INCONEL and INCOLOY alloys, and carbon, low-alloy and stainless steels and for overlaying on to steel.

### Specifications

AWS A5.14 ERNiCrFe-7 (UNS N06052)  
ASME II, Part C, SFA-5.14, ERNiCrFe-7 (UNS N06052)  
ASME IX, F-No.43  
\*(EN) ISO 18274 – SNI6052 (NiCr30Fe9)  
\*Supply to these specifications available upon request  
For manufacture to ASME III (NCA3800, NB2400), and other specifications please refer your inquiry to the Technical Department prior to order placement.

### Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

### Limiting Chemical Composition

Ni+Co .....	Remainder	Cr .....	28.0-31.5
C .....	0.04 max.	Ti .....	1.0 max.
Mn .....	1.0 max.	Al .....	1.10 max.
Fe .....	7.0-11.0	P .....	0.02 max.
S .....	0.015 max.	Nb+Ta .....	0.10 max.
Si .....	0.50 max.	Al+Ti .....	1.5 max.
Mo .....	0.50 max.	Others .....	0.50 max.
Cu .....	0.30 max.		

### Minimum Mechanical Properties

Tensile Strength, psi	80,000
MPa	552
Elongation, (4d) %	30

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

### Available Product Forms

<b>mm</b>	0.8	0.9	1.0	1.14	1.2	1.6	2.4	3.2
<b>in</b>	0.030	0.035	0.040	0.045	0.047	0.062	0.093	0.125

Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)

