

NiCro 52

CATEGORY GMAW-GTAW Solid wires

TYPE Solid nickel base welding wire for Mig (GMAW) welding.

APPLICATIONS 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,

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..

CLASSIFICATION

AWS	A 5.14: ER NiCrFe-7
	UNS: N06052
EN ISO	18274: SNi6052 (NiCr30Fe9)
DIN: W.Nr.	2.4642

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

APPROVALS CE approved

WELDING POSITIONS:



WELD METAL ANALYSIS %

C	Mn	Si	Cr	S	N	Ti	Fe	Co	Cu	Al	Ni
< 0.04	< 1.0	< 0.5	28-31.5	< 0.015	0,014	<1,0	7-11	< 0.12	< 0.3	<1.10	> 58

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V +20°C	Hardness HB
annealed	> 260	> 580	>30		150-240
as drawn	~772	~872	~16		

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Packing	Packing
	Voltage (V)	Current (A) (DC+)	spool type	kg spool
0.8	16-26	80-180	KD-300	15
1.0	16-29	100-250	KD-300	15
1.2	18-29	125-290	KD-300	15

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: 1l, Ar/He (70-30)