

NiCro 72M

CATEGORY GMAW-GTAW Solid wires

APPLICATIONS FM 72M is used for the overlay cladding of ferrous materials used in high temperature applications, and the welding of nickel-chromium-iron alloy

CLASSIFICATION

AWS	AWS A5.14 ERNiCr-7 (UNS N06073)
EN ISO	18274: S Ni 6073
DIN	1736:

SUITABLE FOR ASTM B163, B166, B167, B168 with UNS N06690, IN657, Inco 671/800H

APPROVALS CE Approved

WELDING POSITIONS:



TYPICAL CHEMICAL COMPOSITION (%)

Ni	Cr	Co	Mn	Fe	Si	Mo	Al	Nb+Ta	Others
55	36-39	1.0	0.50	1.0	0.30	0.50	0.75-1.20	0.25-1.0	0.50

MECHANICAL PROPERTIES (TYPICAL)

Heat Treatment	Tensile strength		Elongation (%)
	(PSI)	MPa	
AW	100	690	30

WELDING PARAMETERS PACKING

Welding Parameters		Packing (kg)
D (mm)	Current (A) DC-	Single
1.14		13.6