

## NiCro 72M TIG

**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-4 (UNS N06072)
EN ISO	18274: S Ni 6072 (NiCr44Ti)
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	Ti	Mn	Fe	S	Si	Cu	C
55	36-39	0.6	0.1	0.2	0.008	0.1	0.2	0.01

**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
1.6 x 915 mm		4.54
2.4 x 915 mm		4.54