CEWELD®

Nicro 92

CATEGORY	GMAW-GTAW Solid wires
TYPE	Nickel based Mig / Tig filler metal
APPLICATIONS	Cladding applications to resist extreme high temperatures and thermal shocks in extreme corrosive invironments.
PROPERTIES	Nicro 92 provides high mechanical strenght and corrosion resistance at temperatures ranging from the cryogenic region to over 980ºC. The weld deposit can be age hardened for greater strenght at temperatures to about 700ºC.
CLASSIFICATION	AWS A 5.14: ER NiCrFe-6 UNS: N07092 EN ISO 18274: SNi7092 (NiCr15Ti3Mn)
SUITABLE FOR	Joining Inconel and Incoloy alloys to stainless steels, carbon steels, Monel alloys, joining Monel alloys and Nickel 200 to stainless steels and joining stainless steels to carbon steels. This filler metal can also be used for welding Nickel steels. Excelent for cladding valves and pistons at high working temperature engines.
WELDING POSITIONS:	

FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Mn	Si	Cr	Ni+Co	Mo	Fe	Cu	Ti
<0.08	2.0-2.7	<0.35	14-17	>67	-	<8	<0.5	2.5-3.5

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-60°C	Hardness HRc / HV
AW		552	30				

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
0.9			D-300	13.6	
1.2			D-300	13.6	

REDRYING TEMPERATURE	not required
TIG WELDING	1000 mm cut lenghts are available ranging from 1,6 till 3,2 mm in 5 kg tubes.