



INCONEL[®] Filler Metal 52

INCONEL Filler Metal 52 is used for gas-tungsten-arc and gas-metal-arc 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

mm	0.8	0.9	1.0	1.14	1.2	1.6	2.4	3.2
in	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.)