

# INCONEL<sup>®</sup> Filler Metal 72M

**INCONEL Filler Metal 72M** is used for the overlay cladding of ferrous materials used in high temperature applications, and the welding of nickel-chromium-iron alloy (ASTM B163, B166, B167, and B168 having UNS number N06690) to itself, and to steels, and for welding IN657 and INCO clad 671/800H, using the GTAW, GMAW, and PAW processes. Welds made with this composition are particularly resistant to high temperature oxidation, carburization, and sulfidation, and to reducing-sulfidizing and metal dusting environments.

### Specifications

AWS A5.14 ERNiCr-7 (UNS N06073)  
ASME II, PART C, SFA5.14, ERNiCr-7 (UNS N06073)

### Approvals

Please confirm details of current scope of approvals with the technical Department prior to order placement.

Typical Chemical Composition (%)	Ni..... 55		Ti ..... 0.25 - 0.75	
	Cr..... 36.0 - 39.0	Nb + Ta .....0.25 - 1.0		B .....0.003
Co .....1.0	Mn..... 0.50		C .....0.03	
Fe..... 1.0	Si ..... 0.30		P .....0.02	
Mo .....0.50	Al .....0.75 - 1.20		S.....0.015	
Others .....0.50			Cu ..... 0.30	
			Zr .....0.02	

Typical Mechanical Properties	Tensile Strength, psi		100,000
		MPa	
	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 in	0.8 0.030	0.9 0.035	1.0 0.040	1.14 0.045	1.2 0.047	1.6 0.062	2.4 0.093	3.2 0.125
----------	--------------	--------------	--------------	---------------	--------------	--------------	--------------	--------------

Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.) • Spool weight-13.6 kg (30lb)

INCONEL<sup>®</sup> Filler Metal 72

