



Ni-Cr Filler Metal

INCONEL® 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, SFA.5.14, ERNiCr-7 (UNS N06073)

Approvals

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

Typical Chemical Composition (%)	Typical Mechanical Properties	
	Ni..... 55	Ti 0.25 - 0.75
Cr..... 36.0 - 39.0	Nb + Ta0.25 - 1.0	
Co1.0	B0.003	
Mn..... 0.50	C0.03	
Fe..... 1.0	P0.02	
Si 0.30	S.....0.015	
Mo0.50	Cu 0.30	
Al0.75 - 1.20	Zr0.02	
Others0.50		

Tensile Strength, psi	100,000
MPa	690
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
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Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.) • Spool weight-13.6 kg (30lb)