

Classifications								
EN ISO 18274	AWS A5.14			Mat. No.				
S Ni 6052 (NiCr30Fe9)	ERNiCrFe-7			2.4642				
Characteristics and typical fields of application								
<p>High resistance to stress corrosion cracking in oxidizing acids and water at high temperatures. Particularly suited for the conditions in nuclear fabrication. Useable for joining matching and similar steels, surfacing with low-alloy and stainless steels.</p>								
Base materials								
2.4642 – Alloy 690 – UNS N06690 – NiCr29Fe								
Typical analysis of the TIG rods (wt.-%)								
	C	Si	Mn	Cr	Mo	Ni	Fe	Co
wt-%	0.02	0.2	0.3	29.0	0.1	Bal.	9.0	< 0.1
Structure: Austenite								
Mechanical properties of all-weld metal								
Heat-treatment	Yield strength R _{p0.2}	Tensile strength R _m		Elongation A (L ₀ =5d ₀)		Impact work ISO-V KV J		
	MPa	MPa		%		+20 °C		
aw	380	600		35		100		
Creep rupture properties: According to matching high temperature steels / alloys								
Operating data								
Polarity: DC (–)	Shielding gas: (EN ISO 14175) I1		Marks: † Ni 6052 / ERNiCrFe-7		ø (mm) 1.6 2.0		L mm 1000 1000	
Welding instruction								
Materials			Preheating		Postweld heat treatment			
Matching / similar metals			None		None			