

Classifications

ASME II C SFA 5.14	EN ISO 18274
EQNiCrFe-7	B Ni 6052 (NiCr30Fe9)

Characteristics and typical fields of application

SOUDOTAPE NiCrFe7 is a nickel chromium alloy strip electrode.

With Submerged Arc Strip Cladding flux RECORD NFT NiCrFe7, NiCr30Fe9Nb (near (2.4642) ; (NiCr29Fe9) ; (N06690)) deposit weldoverlay is met from third layer.

With ElectroSlag strip Cladding flux RECORD EST NiCrFe7, NiCr30Fe9Nb (near (2.4642) ; (NiCr29Fe9) ; (N06690)) deposit weldoverlay is met from second layer

Both combinations are compliant with AWS 5.39 weld metal designation NiCrFe-7 and NiCrFe-14
Both combinations have high level of chromium mandatory for stress corrosion resistance in pure water.
Suitable for heat exchangers, steam generators, high temperature applications exposed to caustic solutions.
Widely used for steam generator tubesheets, and hardware in primary and secondary circuit of nuclear power plant.

Alloy 690 has a high degree of metallurgical stability, forming no embrittling phases during long-time exposure to elevated temperatures.
Alloy 690 has excellent resistance to many corrosive aqueous media and high temperature environments.

Typical analysis

	C	Si	Mn	Cr	Ni	Ti	Fe	Al
wt.-%	0.02	0.2	0.7	29.6	Rem.	0.4	9.0	0.6

Typical fluxes to combine

Process	Name	EN ISO 14174
ESW	RECORD EST NiCrFe7	ES A FB 2B
SAW	RECORD NFT NiCrFe7	S A AB 2B

Packaging

Size(s) in mm	Type	Weight
30 x 0,5	Coil	25 - 30 kg
60 x 0,5	Coil	50 - 60 kg
90 x 0,5	Coil	75 - 90 kg

Other sizes and coil weights on request.