



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, 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
Co	1.0	B	0.003
Mn.....	0.50	C	0.03
Fe.....	1.0	P	0.02
Si	0.30	S.....	0.015
Mo	0.50	Cu	0.30
Al	0.75 - 1.20	Zr	0.02
Others	0.50		

Typical Mechanical Properties

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)