



Ni-Cr-Fe Filler Metal

INCONEL® Filler Metal 92

INCONEL Filler Metal 92 is used for gas-tungsten-arc and gas-metal-arc welding of austenitic and ferritic steels and nickel alloys. Applications include joining INCONEL and INCOLOY alloys to stainless steels, carbon steels, and MONEL alloys; joining MONEL alloys and Nickel 200 to stainless steels; and joining stainless steels to carbon steels. The filler metal is also used for welding nickel steels. The high Ti concentration provides excellent porosity resistance in field welding applications.

INCONEL Filler Metal 92 provides high strength and corrosion resistance at temperatures ranging from the cryogenic region to over 1800°F (980°C). Weld deposits can be age hardened for greater strength at temperatures to about 1300°F (700°C).

Specifications

AWS A5.14 ERNiCrFe-6 (UNS N07092)

ASME II, Part C, SFA-5.14, ERNiCrFe-6 (UNS N07092)

ASME IX, F-No.43

*BS 2901 NA39

*(EN) ISO 18274 – SNI 7092 (NiCr15Ti3Mn)

*Supply to these specifications available upon request

For manufacture to ASME III NCA3800, NB2400, MIL, Rolls Royce, AMS and other specifications please refer your inquiry to the Technical Department prior to order placement.

Approvals

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

**Limiting
Chemical
Composition**

Ni+Co	67.0 min.	Cu.....	0.50 max.
C.....	0.08 max.	Cr	14.0-17.0
Mn	2.0-2.7	Ti.....	2.5-3.5
Fe.....	8.0 max.	P	0.03 max.
S	0.015 max.	Others	0.50 max.
Si.....	0.35 max.		

**Minimum
Mechanical
Properties
(As Welded)**

Tensile Strength, psi	80,000
MPa	552
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.)