



## TIG NI690

### Classification

AWS A5.14 : ERNiCrFe-7A

ISO 18274 : S Ni6054 (NiCr29Fe9)

### Description & Applications

Solid rod for GTAW of Nickel alloys type Alloy 690. Excellent resistance to corrosion and high temperature oxidation. Could be used in cladding for low alloys or stainless steels but also for heterogeneous assembly between steel and nickel.

**Main applications:** Nuclear industry, chemical and petrochemical industry.

### Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Mo	Cu	P	S	Fe
Min				28.0					7.0
Max	0.04	0.50	1.0	31.5	0.50	0.30	0.02	0.015	11.0
Type	0.02	0.20	0.40	30.0	0.01	0.01	0.007	0.003	9.0

  

	Nb+Ta	Al	Ti	Co	Zr	B	Al+Ti	Ni
Min	0.5							51.0
Max	1.0	1.10	1.0	0.12	0.02	0.005	1.5	
Type	0.70	0.50	0.50	0.01	<0.02	<0.005	1.0	>51.0

### All Weld Metal Mechanical Properties

	R <sub>p0.2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	-	-	-	-
Max				
Type	410	640	37	+20°C 180

### Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175: I1 (Ar) : 6-12 l/min Back shielding : I1 (Ar) : 3-6 l/min

FT-En-TI14-230621

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