Inweld Nickel 62

AWS A5.14 ERNiCrFe-5

Chemical Composition of Inweld Nickel 62

Fe	C	Cr	Ni	Co	Mn	Si	P	S	Cb+Ta	Cu	Other
6.0-10.0	0.08	14.0-17.0	70.0 min	0.12	1.0	0.35	0.03	0.015	1.5-3.0	0.50	0.50

Single values are maximum unless otherwise specified.

Description and Applications

Inweld Nickel 62 is a nickel-chromium-iron filler metal used for MIG, TIG, Plasma Arc and Submerged Arc welding on Inconel 600 base metal that has a maximum thickness of 2". (For sections thicker than 2"use Nickel 82). The columbium (Cb) content of Nickel 62 is intended to minimize cracking where high welding stresses are encountered which generally occur when welding thicker sections under 2". The weld metal will exhibit the same high temperature strength and oxidation resistance as the base metal. Nearest coated electrode equivalent is Inweld 132 ENiCrFe-1.

Typical Weld Metal Properties

	AWS Spec
Tensile Strength:	80,000 psi
Yield Strength:	40,000 psi
Elongation:	30%

Recommended Parameters

GMAW (DCRP – Electrode+) Spray Transfer 100% Ar

Wire Diameter	Voltage	Amperage
0.035”	26-32	175-240
0.045”	26-32	225-300
1/16”	27-33	250-330

GTAW (DCSP – Electrode-) 100% Ar 2% Thoriated, 2% Ceriated or Lanthanum Tungsten Electrode

Wire Diameter	Voltage	Amperage
1/16”	70-120	70-150
3/32”	120-160	140-230
1/8”	170-230	225-320
5/32”	220-280	175-300