

Exaton Ni72HP (GTAW)

Exaton Ni72HP is filler material for joining NiCrFe alloys, such as UNS N06600, UNS N06601, UNS N06690, UNS N08810 and UNS N08330, 9% Ni steels used at cryogenic temperatures, stainless steels to carbon steels, high service temperature NiCu alloys to carbon steels and NiCu alloys to nickel alloys. Exaton Ni72HP can be used in air up to 1175°C (2145°F) and in sulphur dioxide atmospheres up to 800°C (1470°F). Exaton Ni72HP can be used for dissimilar joining of stainless steels to nickel alloys, for overlay welding with MIG/MAG as well as hot wire TIG and mechanical TIG.

Specifications

Classifications	SFA/AWS A5.14 : ERNiCr-3 EN ISO 18274 : S Ni 6082 (NiCr20Mn3Nb)
Approvals	VdTÜV : 00515

Alloy Type	Alloyed nickel (Ni + 20 % Cr + 3 % Mn + 2.5 % Nb)
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Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	480 MPa	720 MPa	40 %
As Welded 350 °C	400 MPa	620 MPa	37 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	20 °C	230 J
As Welded	-196 °C	150 J

Typical Wire Composition %

Typical Weld Metal Analysis %