



# Selectarc TIG NI 690

## TIG Filler

### Classification

AWS A5.14 : ERNiCrFe7

### Charateristics

High Chromium content Nickel base Filler wire, used for repair and fabrication welding of alloy 690 and 600. Also applied for dissimilar jointing between Stainless steels and Carbon steels. Regular weld deposit.

### Applications

Nuclear power plants, Chemical industries...

#### Base materials

UNS	Alloy	EN	Material N°
N06690	690	NiCr29Fe	2.4642
N06600	600	NiCr15Fe	2.4816

### Typical Weld Metal Composition ( % )

C	Si	Mn	Cr	Mo	Nb	Fe	S	P	Al	Ti	Cu	Ni
0.030	0.40	0.60	28.50	0.20	1.20	7.20	0.010	0.020	0.05	0.10	0.10	Rem.

### All Weld Metal Mechanical Properties (Typical)

R <sub>p0,2</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV (J)
420	640	40	+20°C 100

### Welding Current & Instructions

Welding Polarity	Shielding Gas
TIG/-	Ar: 6-12l/min Back Shielding : Argon:3-6l/min

Nickel base alloys are welded without preheating and an inter-pass temperature <150°C. For repair welding of steels with a high carbon content a preheating between 200- 500°C has to be applied. A post weld heat treatment can be performed without influence on the weld deposit.

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