

# ENiCrFe-7 Welding Electrode

## For Welding Nickel-Chromium-Iron Alloy 690

ENiCrFe-7 is engineered for nickel-chromium-iron Alloy 690, offering enhanced resistance to stress-corrosion cracking, particularly in high-purity water and nuclear environments. It produces high-quality welds in all positions.

It also allows corrosion-resistant overlays on most stainless and low-alloy steels, and is highly effective for dissimilar welding applications, including nuclear waste glass melters and specialized industrial repairs.

## Specification

AWS A5.11 ENiCrFe-7 (UNS W86152)

ASME II, Part C, SFA-5.11, ENiCrFe-7 (UNS W86152)

ASME IX, F-No.43

\*(EN) ISO 14172 – ENi6152 (NiCr30Fe9Nb)

Custom specifications available upon request.

For information regarding certifications and industry approvals, please contact our Technical Department.

## Limiting Chemical Composition

Element	Ni+Co	C	Mn	Fe	S	Si	Mo
Content(%)	Remainder	0.05 max	5.0 max	7.0-12.0	0.015 max	0.75 max	0.50 max
Element	Cu	Cr	Ti	Al	P	Nb+Ta	Others
Content(%)	0.50 max	28.0-31.5	0.50 max	0.50 max	0.03 max	1.0-2.5	0.50 max

## Minimum Mechanical Properties

Property	Value
Tensile Strength, psi	80,000
MPa	552
Elongation, (4d) %	30

## Available Product Forms – Supplied in 10lbs (4.54kg) hermetically sealed containers

Diameter	mm in	2.4 3/32	3.2 1/8	4.0 5/32	4.8 3/16
Length	mm in	229 12	356 14	356 14	356 14
Current (DC+)	A	45-65	75-100	95-130	125-165