

# ERNiCr-7 Filler Metal

## For Welding and Overlay of Alloy 690 and Ferrous Materials

**ERNiCr-7 filler metal** is used for overlay cladding of ferrous materials in high-temperature applications and for welding nickel-chromium-iron Alloy 690 (UNS N06690) to itself or to steels. It is also suitable for welding IN657 and clad alloys such as 671/800H using GTAW, GMAW, and PAW processes.

The weld metal provides excellent resistance to high-temperature oxidation, carburization, sulfidation, and metal dusting, making it ideal for demanding chemical, power, and industrial environments where reducing-sulfidizing conditions exist.

## Specification

AWS A5.14 ERNiCr-7 (UNS N06092)

ASME II, PART C, SFA5.14, ERNiCr-7 (UNS N06092)

Custom specifications available upon request.

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

## Typical Chemical Composition(%)

Element	Ni	Cr	Fe	Mn	Si	C
Content(%)	Remainder	28.0-31.5	7.0-11.0	≤1.0	≤0.5	≤0.04
Element	Cu	Ti	Al	P	S	Others
Content(%)	≤0.30	≤1.0	≤1.10	≤0.020	≤0.015	≤0.50

## Typical Mechanical Properties

Property	Value
Tensile Strength, psi	100,000
MPa	690
Elongation, (4d) %	30

## Available Product Forms

mm in	0.8 0.030	0.9 0.035	1.0 0.040	1.14 0.045	1.2 0.047	1.6 0.062	2.4 0.093	3.2 0.125
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Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.) • Spool weight-13.6 kg (30lb)