

Prepared by	Qualified by	Approved by	Reg no	Cancelling	Reg date	Page
Sasi Kumar R.	P-O Oskarsson	Paolo Torchiana	EN009163	EN009064	2020-05-05	1 (1)

REASON FOR ISSUE

Chemical composition updated (more elements added).

GENERAL

Exaton Ni72HP is a strip electrode used to obtain a ERNiCr-3 (UNS N06600) corrosion resistant overlay weld deposit on C-, CMn- and low-alloy steels using electroslag welding (ESW) with Exaton 69S or submerged arc welding (SAW) with Exaton 50SW flux. Other combinations and conditions are possible.

CLASSIFICATIONS Strip

SFA/AWS A5.14 EQNiCr-3
EN ISO 18274 B Ni 6082

APPROVALS

CE EN 13479

APPROVAL COMMENT

Contact your nearest sales office for details.

CHEMICAL COMPOSITION**Wire/Strip (%)**

	Nom
C	<=0.030
Si	0.1
Mn	3
P	<=0.01
S	<=0.01
Cr	20
Ni	72
Cu	0.01
Ti	0.27
Fe	0.33
Nb+Ta	2.70

OTHER DATA

Exaton Ni72HP is mostly used for corrosion resistant weld surfacing of components in the nuclear industry – for example, tube sheets and closure heads of steam generators.