

NILO[®] Filler Metal CF42

NILO Filler Metal CF42 is used for the gas-metal-arc, gas-tungsten-arc, and submerged-arc welding of NILO alloy 42. NILO Filler Metal CF42 is formulated to have low thermal expansion characteristics similar to NILO alloy 42, while providing freedom from solidification and reheat cracking. Argon is recommended for the GMAW-Spray process, Argon/25% helium for the GMAW-Pulsed Arc and Short-Arc processes, and INCOFLUX 6 for the SAW process.

Specifications none

Approvals

Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Typical Chemical Composition	Ni	41
	Fe	58
	C	0.2
	Mn	0.4
	Nb	1.2

Typical Mechanical Properties	Tensile Strength, psi	80,000
	MPa	550
	Elongation, (4d) %	25

Filler metals available on spool and in cut straight lengths in a variety of sizes selected from the following diameters:

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.)

