

## NILO<sup>®</sup> Filler Metal CF36

**NILO Filler Metal CF36** is used for the gas-metal-arc, gas-tungsten-arc, and submerged-arc welding of NILO alloy 36. Filler Metal CF36 is formulated to have low thermal expansion characteristics similar to NILO alloy 36, 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.

|   |         |     |
|---|---------|-----|
| <b>Typical<br/>Chemical<br/>Composition</b> | Ni..... | 36  |
|   | Fe..... | 62  |
|   | C.....  | 0.2 |
|   | Mn..... | 0.4 |
|   | Nb..... | 1.6 |

|  |                       |        |
|--|-----------------------|--------|
| <b>Typical<br/>Mechanical<br/>Properties</b> | 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

|           |       |       |       |       |       |       |       |       |
|-----------|-------|-------|-------|-------|-------|-------|-------|-------|
| <b>mm</b> | 0.8   | 0.9   | 1.0   | 1.14  | 1.2   | 1.6   | 2.4   | 3.2   |
| <b>in</b> | 0.030 | 0.035 | 0.040 | 0.045 | 0.047 | 0.062 | 0.093 | 0.125 |

Straight Lengths - 915 mm (36 in.) or 1000 mm (39 in.)