



CEWELD E NiCrMo 686 CPT

TYPE	Nickel based electrode for NiCrMo welding. (Type ENiCrMo-14, Alloy 686, 2.4606)								
APPLICATIONS	CEWELD® E NiCrMo 686 CPT is designed to weld alloy 686. She is also suitable to overmatching 625, C276, C4, C22, 59 alloys. Also suitable to weld superduplex and superaustenitic steels. Chemical and petrochemical industry, application of corrosion-resistant overlays and valve seat inserts, exhaust gas desulphurization plants								
PROPERTIES	CEWELD® E NiCrMo 686 CPT weld metal is exceptionally resistant to pitting, crevice corrosion and general corrosion. It is suitable for butt and fillet welds in all positions with diameters of 2.4 and 3.2 mm.								
CLASSIFICATION	AWS	A 5.11: E NiCrMo-14							
	EN ISO	14172: E Ni 6686 (NiCr21Mo16W4)							
	W.Nr.	~ 2.4606							
	F-nr	43							
	FM	6							
SUITABLE FOR	ENiCrMo-14, E Ni 6686 NiCr21Mo16W4 2.4602, 2.4605, 2.4606, 2.4607, 2.4610, 2.4819, 2.4656, 1.4529,1.4547, 1.4565 NiCr23Mo16, NiCr23Mo16Al, NiCr21Mo16W, NiMo16Cr15Ti, NiMo16Cr16Ti, NiCr21Mo14W, NiMo16Cr15W, NiCr22Mo9Nb, Alloy 59, Alloy C4, Alloy 276, X1NiCrMoCuN25-20-7, X1CrNiMoCuN20-18-7 ASTM: C-4, C-276, C-22, 625, 904hMo UNS: N06059, N06455, N10276, N06625, N08925, S31254,N06686, N06022, N06059, N06200, N08367, N08926, N08031 Duplex, Superduplex, super austenitic stainless steel, Nickel Alloys, N06059, N06022, Hastelloy C276, Alloy C22, Alloy 59. Inconel 622, 625, 686, Outokumpu 654 SMO, Incoloy® Alloy 25-6MO, 27-7MO (Special Metals)								
APPROVALS									
WELDING POSITIONS									
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo	Fe	W	Cu
	0.01	0.18	0.8	22	55	16	4	3.8	0.35
MECHANICAL PROPERTIES	Heat Treatment		R _{P0.2} (MPa)	R _m (MPa)		A5 (%)	Hardness		
	As Welded		380	740		34	HRc		
REDRYING	300°C / 2 hr								
GAS ACC. EN ISO 14175									



CEWELD E NiCrMo 686 CPT

E NICKRMO 686 CPT 2,4 X
229MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419453

E NICKRMO 686 CPT 3,2 X
356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419460

E NICKRMO 686 CPT 4,0 X
356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419477