



# CEWELD E Alloy HX

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |
|---------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------|
| TYPE                                        | Nickel-based alloy rod electrode. (Type Alloy HX, Ni6002, E NiCrMo-2)                                                                                                                                                                                                                                                                                                                                                                                               |                                 |
| APPLICATIONS                                | <b>CEWELD® E Alloy HX</b> is a nickel-chromium-iron-molybdenum stick electrode with an exceptional combination of oxidation resistance, ease of fabrication and high temperature strength. It has also proven to be exceptionally resistant to stress corrosion cracking in petrochemical applications. Applications in gas turbines and industrial furnaces. Because of its good resistance to stress corrosion cracking, also used in the petrochemical industry. |                                 |
| PROPERTIES                                  | <b>CEWELD® E Alloy HX</b> is a high temperature resistant, solid solution strengthened alloy with improved mechanical properties and good oxidation resistance up to 1095°C.                                                                                                                                                                                                                                                                                        |                                 |
| CLASSIFICATION                              | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | A 5.11: E NiCrMo-2              |
|                                             | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 14172: E Ni 6002 (NiCr22Fe18Mo) |
|                                             | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 2.4665                          |
|                                             | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                | 43                              |
|                                             | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 6                               |
| SUITABLE FOR                                | 2.4665<br>NiCr19Fe19Nb5Mo3<br>Inconel HX, Nicrofer 4722 Co, Pyromet 680, Hasteloly HX, Alloy HX                                                                                                                                                                                                                                                                                                                                                                     |                                 |
| APPROVALS                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |
| WELDING POSITIONS                           |                                                                                                                                                                                                                                                                                                 |                                 |
| TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%) |                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |
| MECHANICAL PROPERTIES                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |
| REDRYING                                    | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                 |
| GAS ACC. EN ISO 14175                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                     |                                 |