



# CEWELD NiCr 602 CA

**TYPE** Nickel based filler metal against extreme temperature conditions.

**APPLICATIONS** Welding similar alloys that have to resist extreme high temperature and for cladding steels or stainless steels to obtain a high temperature resistant surface against oxidation.

**PROPERTIES** Excellent welding properties with high build-up capacity and low dilution rate. Excellent resistance against temperature cycling conditions up to 1200°C and carburized medias. Excellent fatigue strength and creep properties.

**CLASSIFICATION**

AWS	A 5.14: ERNiCrFe-12
EN ISO	18274: S Ni 6025(NiCr25Fe10AlY)
W.Nr.	2.4649
F-nr	43
FM	6

**SUITABLE FOR** Cladding against high temperature, radiant heater tubes, furnace rolls, muffles in bright annealing furnaces (H2 atmosphere), rotary kilns, pipe hangers, waste gas components, hydrogen production, methanol and ammonia synthesis, 2.4633, 2.4649, NiCr25FeAlY, Nicrofer 6025 HT, Alloy 602CA, UNS N06025, Centralloy HTE

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Cr	Ni	Ti	Fe	Al
0.2	0.4	0.4	25	65	0.15	10	2

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	520	750	26	50		HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1



# CEWELD NiCro 602 CA

NICRO 602 CA 1,0MM

Packaging	KG/unit	EanCode
BS-300	15	8720663418333

NICRO 602 CA 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663418340

NICRO 602 CA 1,6MM

Packaging	KG/unit	EanCode
BS-300	10,9	8720663418357