



CEWELD NiCrO 600

| | | |
|-----------------------|---|--------------------------------|
| TYPE | Solid nickel base welding wire for GMAW welding. | |
| APPLICATIONS | CEWELD NiCrO 600 filler metal is used for welding nickel-chromium-iron (Inconel 600, 601 and 690) alloys to themselves, and for dissimilar welding between nickel-chromium-iron (Monel, Inconel and Incoloy) alloys and steels or stainless steels. The applications include surfacing as well as clad-side welding. | |
| PROPERTIES | High manganese of this weld deposit reduces the possibility of micro fissures. High toughness at low temperatures (-269 °C). Heat- and high temperature resistant. Good resistance to hotcracking. Temperature limits: 900 °C max. | |
| CLASSIFICATION | AWS | A 5.14: ERNiCr-3 |
| | EN ISO | 18274: S Ni 6082 (NiCr20Mn3Nb) |
| | W.Nr. | 2.4806 |
| | F-nr | 43 |
| | FM | 6 |
| SUITABLE FOR | E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3, Ni 6082 (NiCr20Mn3Nb) 2.4630, 2.4631, 2.4669, 2.4816, 2.4817, 2.4851, 2.4867, 2.4870, 2.4951 ... (1.4816, 1.4864, 1.4876, 1.4583, 1.4886, 1.5637, 1.5662, 1.5680, 1.6900, 1.6901, 1.6903, 1.6906) NiCr20Ti, NiCr21TiAl, NiCr15Fe7TiAl, NiCr15Fe, LC-NiCr15Fe, NiCr23Fe, NiCr60 15, NiCr80 20, NiCr 10, NiCr20Ti 1.5637 12 Ni 14, X8Ni9, 12Ni19, X12CrNi18 9, GX8CrNi18 10, X10CrNiTi18 10, X5CrNi18 10 UNS Nr: K81340 - N06600 - N06601 - N08800 - N08810 ASTM B163, B166, B167 und B168 Alloy 330, Alloy 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810 | |

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

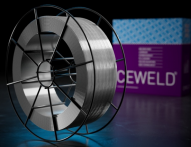
| C | Si | Mn | Cr | Ni | Nb | Ti | Fe |
|------|-----|-----|----|------|-----|-----|-----|
| 0.04 | 0.1 | 2.9 | 20 | 72.5 | 2.4 | 0.4 | 1.3 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
| | | | | RT | -196°C | |
| As Welded | 420 | 650 | 35 | 150 | 100 | HRC |

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD NiCro 600

NICRO 600 0,8MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663418401 |

NICRO 600 1,0MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 13,6 | 8720663418425 |
| BS-300 | 15 | 8720663418418 |

NICRO 600 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 13,6 | 8720663418449 |
| BS-300 | 15 | 8720663418432 |

NICRO 600 1,6MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663418456 |