



CEWELD AA NiCro 600

TYPE	Rutile flux-cored nickel base welding wire for gas shielded arc welding.							
APPLICATIONS	AA NICRO 600 is developed for welding and cladding nickel-based alloys such as alloy 600 or similar materials. This alloy can also be used for welding dissimilar nickel-based alloys to each other, to alloyed steels or to stainless steels. AA NICRO 600 can also be used on difficult to weld steels ! Difficult to weld steel, chain, cock wheels, kiln tyre Dissimilar-welding applications include joining INCONEL alloys, INCOLOY alloys and INCOLOY alloy 330 to nickel, MONEL alloys, stainless steels, and carbon steels. Joining stainless steels to nickel alloys and carbon steels							
PROPERTIES	High mechanical properties with excellent weldability due to improved wetting compare to solid wire.							
CLASSIFICATION	AWS	A 5.34: E NiCr3T1-4						
	EN ISO	12153-A: T Ni 6082 (NiCr20Mn3Nb) R M21 3						
	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	PA PB PC							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Nb	Ti	Fe
	0.045	0.3	5.5	16.5	70	2	0.3	2.1
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	
					0°C	-196°C		
	As Welded	390	650	45	130	125	HRc	
REDRYING	140°C / 24 hr							
GAS ACC. EN ISO 14175	M21							



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AA NICRO 600 1,2MM

Packaging	KG/unit	EanCode
BS-300	12,5	8720663418814