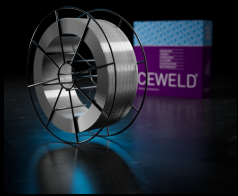


# CEWELD NiCro 600

|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                         |                      |                    |                         |        |          |     |
|------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------|----------------------|--------------------|-------------------------|--------|----------|-----|
| TYPE                                           | Solid nickel base welding wire for GMAW welding.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                                                         |                      |                    |                         |        |          |     |
| ANWENDUNGEN                                    | 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.                                                                                                                                                                                                                                                                                                                                      |                                                                         |                      |                    |                         |        |          |     |
| EIGENSCHAFTEN                                  | 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.                                                                                                                                                                                                                                                                                                                                                                                                                        |                                                                         |                      |                    |                         |        |          |     |
| KLASSIFIKATION                                 | AWS<br>EN ISO<br>W.Nr.<br>F-nr<br>FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | A 5.14: ERNiCr-3<br>18274: S Ni 6082 (NiCr20Mn3Nb)<br>2.4806<br>43<br>6 |                      |                    |                         |        |          |     |
| GEEIGNET FÜR                                   | <b>E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3, Ni 6082 (NiCr20Mn3Nb)</b><br>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)<br>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<br><b>UNS Nr:</b> K81340 - N06600 - N06601 - N08800 - N08810<br><b>ASTM</b> B163, B166, B167 und B168<br>Alloy 330, Alloy 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810 |                                                                         |                      |                    |                         |        |          |     |
| ZULASSUNGEN                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                         |                      |                    |                         |        |          |     |
| SCHWEISSPOSITIONEN                             | <div>     </div>                                                                                                                        |                                                                         |                      |                    |                         |        |          |     |
| TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Si                                                                      | Mn                   | Cr                 | Ni                      | Nb     | Ti       | Fe  |
|                                                | 0.04                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 0.1                                                                     | 2.9                  | 20                 | 72.5                    | 2.4    | 0.4      | 1.3 |
| MECHANISCHE GÜTEWERTE                          | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | R <sub>P0,2</sub> (MPa)                                                 | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |     |
|                                                |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                                                         |                      |                    | RT                      | -196°C |          |     |
|                                                | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 420                                                                     | 650                  | 35                 | 150                     | 100    | HRc      |     |
| RÜCKTROCKNUNG                                  | 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 |