



CEWELD E NiCr 600

TYPE High basic nickel-based stick electrode for welding. (Type E Ni 6182, E NiCrFe-3)

APPLICATIONS **CEWELD® E NiCr 600** is used for welding nickel-chromium-iron alloys (Inconel 600, 601 and 690) to themselves and for dissimilar welds between nickel-chromium-iron alloys (Monel, Inconel and Incoloy) and steels or stainless steels. Applications include both build-up welding and clad side welding, welding of heat resistant alloys in furnaces, dissimilar welding between nickel-based alloys (including Monel) and stainless steels, low alloy steels and carbon steels.

PROPERTIES The high manganese content of this **CEWELD® E NiCr 600** weld metal reduces the possibility of microcracks. High mechanical properties with excellent thermal shock resistance and notched impact strength at sub-zero temperatures down to -196 °C.

CLASSIFICATION

AWS	A 5.11: E NiCrFe-3
EN ISO	14172: E Ni 6182
W.Nr.	2.4807
F-nr	43
FM	6

SUITABLE FOR **E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3**
 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 WELD METAL (%)

C	Si	Mn	Cr	Ni	Ti	Fe	Nb+Ta	Nb
0.08	0.8	8.5	15	70	0.5	5	2	1.5

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	>360	600	34	HRc

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E NiCro 600

E NICRO 600 2,4 X 229MM	Packaging	KG/unit	EanCode
	Can	2,27	8720663418548
E NICRO 600 3,2 X 356MM	Packaging	KG/unit	EanCode
	Can	2,27	8720663418555
E NICRO 600 4,0 X 356MM	Packaging	KG/unit	EanCode
	Can	2,27	8720663418562
E NICRO 600 4,8 X 356MM	Packaging	KG/unit	EanCode
	Can	2,27	8720663418579