



# CEWELD SA Nicro 600 strip



TYPE Nickel Chromium solid strip

APPLICATIONS This strip is suitable for both electroslog (ESW) and sub arc (SAW) process. Typical applications include cladding of vessels for the petrochemical, refinery and chemical industries

PROPRIÉTÉS Weld metal deposited by SA Nicro 600 has high strength and good corrosion resistance, including oxidation resistance and creep-rupture strength at elevated temperatures. Use FL 860 ESHC flux

CLASSIFICATION  
AWS A 5.14: EQNiCr-3  
EN ISO 18274: B Ni 6082 (NiCr20Mn3Nb)  
W.Nr. 2.4806

CONVIENT POUR SA Nicro 600 is mainly used for ESW and SAW cladding of carbon steel to obtain corrosion and creep resistant layers. Go to [FL 860 ESHC](#) suitable flux  
**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 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810

AGRÉMENTS

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE  
TYPIQUE DU MÉTAL  
D'APPORT (%)

| C    | Si  | Mn | P    | S    | Cr | Ni | Nb  | Ti  | Fe |
|------|-----|----|------|------|----|----|-----|-----|----|
| 0.08 | 0.4 | 3  | 0.02 | 0.01 | 21 | 75 | 2.8 | 0.2 | 2  |

PROPRIÉTÉS MÉCANIQUES

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      | 390                     | 650                  | 37                 | HRc      |

ETUVAGE Not required

GAS ACC. EN ISO 14175