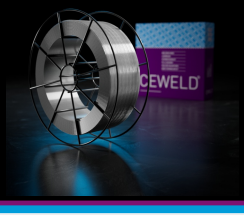


CEWELD NiCro 600

certilas® THE FILLER METAL SPECIALIST

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	A 5.14: ERNiCr-3
EN ISO	18274: S Ni 6082 (NiCr20Mn3Nb)
W.Nr.	2.4806
F-nr	43
FM	6

GEEIGNET FÜR

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 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810

ZULASSUNGEN

SCHWEISSPOSITIONEN

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

MECHANISCHE GÜTEWERTE

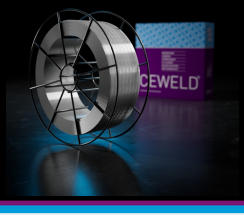
Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	420	650	35	150	100	HRc

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

I1



CEWELD NiCro 600

certilas® THE FILLER METAL SPECIALIST

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