

CEWELD NiCrMo 686 CPT



TYPE Nickel-Chromium-Molybdenum based alloy for gas metal arc welding

APPLICATIONS NICrMo 686 is of great value for service environments requiring general corrosion-resistance in HCI

or sulfuric acid; for resistance to crevice corrosion in hot, concentrated acid chloride solutions such as sulfur dioxide saturated NaCl solutions and oxidizing chloride solutions; and for resistance to intergranular attack, after sensitization, in highly

oxidizing environments.

PROPERTIES NiCrMo 686 (UNS N06686/W.Nr. 2.4606) is a single-phase, austenitic Ni-Cr-Mo-W alloy offering

outstanding corrosion-resistance in a range of severe environments. Its high nickel (Ni) and molybdenum (Mo) provide good resistance in reducing conditions, and high chromium (Cr) offers resistance to oxidizing media. Molybdenum (Mo) and tungsten (W) aid resistance to localized corrosion such as pitting. Iron (Fe) is closely controlled to enhance properties. Low carbon (C) helps minimize grain boundary precipitation to maintain corrosion-resistance in the heat-affected zones of welded joints. Resistance to general, pitting and crevice corrosion increases with the alloying

(Cr+Mo+W) content, and NiCrMo 686 scores higher than competitive materials.

CLASSIFICATION AWS A 5.14: ERNiCrMo-14

EN ISO 18274: S Ni 6686 (NiCr21Mo16W4)

W.Nr. ~2.4606 F-nr 43 FM 6

SUITABLE FOR ENICrMo-14, E Ni 6686 NiCr21Mo16W4

2.4602, 2.4605, 2.4607, 2.4610, 2.4819, 2.4656, 1.4529, 1.4547, 1.4565

NiCr23Mo16, NiCr23Mo16Al, NiMo16Cr15Ti, NiMo16Cr16Ti, NiCr21Mo14W, NiMo16Cr15W, NiCr22Mo9Nb, Alloy 59, Alloy C4, Alloy 276, X1NiCrMoCuN25-20-7, X1CrNiMoCuN20-18-7

ASTM: C-4, C-276, C-22, 625, 904hMo

UNS: N06059, N06455, N10276, N06022, N06625, N08925, S31254

Duplex, Superduplex, super austenitic stainless steel, Nickel Alloys, N06059, N06022, Hastelloy

C276, Alloy C22, Inconel 622, 625, 686, Outokumpu 654 SMO,

APPROVALS

WELDING POSITIONS

PA PB PC PD PE PF

TYPICAL CHEMICAL
ANALYSIS OF THE FILLER

METAL (%)

С	Si	Mn	Р	S	Cr	Ni	Мо	Ti	Fe	W	Cu	Al
0.03	0.06	0.3	0.002	0.001	21	58	16	0.1	0.8	3.5	0.01	0.23

MECHANICAL PROPERTIES

Heat	R _{P0,2}	Rm	A5	Hardness	
Treatment	(MPa)	(MPa)	(%)		
As Welded		760		HRc	

REDRYING Not required

GAS ACC. EN ISO 14175 11, I3



CEWELD NiCrMo 686 CPT



NICRMO 686 CPT 0,8MM	Packaging	KG/unit	EanCode			
	BS-300	15	8720663419484			
NICRMO 686 CPT 1,0MM	Packaging	KG/unit	EanCode			
	BS-300	15	8720663419507			
NICRMO 686 CPT 1,14MM	Packaging	KG/unit	EanCode			
	BS-300	13,6	8720663419521			
NICRMO 686 CPT 1,6MM	Packaging	KG/unit	EanCode			
	BS-300	15	8720663419538			