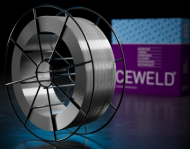


CEWELD NiCr 600

TYPE	Solid nickel base welding wire for GMAW welding.																
APPLICATIONS	CEWELD NiCr 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.																
PROPERTIES	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.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCr-3</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 6082 (NiCr20Mn3Nb)</td> </tr> <tr> <td>W.Nr.</td> <td>2.4806</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.14: ERNiCr-3	EN ISO	18274: S Ni 6082 (NiCr20Mn3Nb)	W.Nr.	2.4806	F-nr	43	FM	6						
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W.Nr.	2.4806																
F-nr	43																
FM	6																
SUITABLE FOR	<p>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</p>																
APPROVALS																	
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Nb</th> <th>Ti</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.04</td> <td>0.1</td> <td>2.9</td> <td>20</td> <td>72.5</td> <td>2.4</td> <td>0.4</td> <td>1.3</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Nb	Ti	Fe	0.04	0.1	2.9	20	72.5	2.4	0.4	1.3
C	Si	Mn	Cr	Ni	Nb	Ti	Fe										
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MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-196°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>420</td> <td>650</td> <td>35</td> <td>150</td> <td>100</td> <td>HRC</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	RT	-196°C	As Welded	420	650	35	150	100	HRC
Heat Treatment	R _{P0,2} (MPa)					R _m (MPa)	A ₅ (%)		Impact Energy (J) ISO-V		Hardness						
		RT	-196°C														
As Welded	420	650	35	150	100	HRC											
REDRYING	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