



# CEWELD E NiCrMo C4

**TYPE** Nickel based electrode for NiCrMo C4 welding

**APPLICATIONS** CEWELD E NiCrMo C4 is used for welding nickel-chromium-molybdenum alloy, for welding of the clad side of joints in steel clad with nickel-chromium-molybdenum alloy, and for joining nickel-chromium-molybdenum alloys to steel and to other nickel-base alloys

**PROPERTIES** Due to the combination of chromium with high molybdenum content receives CEWELD E NiCrMo C4 exceptional resistance to a variety of chemical media such as contaminated, reducing mineral acids, chlorides and organic as well as inorganic chloride contaminated media.

**CLASSIFICATION**

AWS	A 5.11: E NiCrMo-7
EN ISO	14172: E Ni 6455
F-nr	43
FM	6

**SUITABLE FOR**

Alloy C4  
 ASTM B574, B575, B619, B622, B626  
 UNS N06455

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	P	S	Cr	Ni	Mo	Ti	Fe	Co
0.01	0.11	0.9	0.01	0.001	16.3	Rem.	14.8	0.2	0.5	0.7

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Hardness
As Welded	430	710	31	HRc

**REDRYING** 140°C / 1 hr

**GAS ACC.** EN ISO 14175