



CEWELD E NiCro 600

| | | | | | | | | | | | |
|----------------|---|-----|--------------------|--------|------------------|-------|--------|------|----|----|---|
| TYPE | Nickel based high basic SMAW welding electrode. | | | | | | | | | | |
| APPLICATIONS | CEWELD E NiCro 600 electrodes are used for welding of 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. High manganese of this weld deposit reduces the possibility of micro fissures. High manganese reduces creep strength, which limits its usage up to 480 °C(900 °F) | | | | | | | | | | |
| PROPERTIES | High mechanical properties with excellent thermal shock resistance and impact values at sub zero temperatures down to -196 °C | | | | | | | | | | |
| CLASSIFICATION | <table border="0"> <tr> <td>AWS</td> <td>A 5.11: E NiCrFe-3</td> </tr> <tr> <td>EN ISO</td> <td>14172: E Ni 6182</td> </tr> <tr> <td>W.Nr.</td> <td>2.4807</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table> | AWS | A 5.11: E NiCrFe-3 | EN ISO | 14172: E Ni 6182 | W.Nr. | 2.4807 | F-nr | 43 | FM | 6 |
| AWS | A 5.11: E NiCrFe-3 | | | | | | | | | | |
| EN ISO | 14172: E Ni 6182 | | | | | | | | | | |
| W.Nr. | 2.4807 | | | | | | | | | | |
| F-nr | 43 | | | | | | | | | | |
| FM | 6 | | | | | | | | | | |
| SUITABLE FOR | <p>Dissimilar welds for which the electrode are used include INCONEL alloys and INCOLOY or Hastelloy alloys joined to carbon steels, stainless steels, nickel and MONEL alloys, MONEL alloys joined to carbon steels; nickel joined to stainless steels; and stainless steels joined to carbon steels.</p> <p>1.4816, 1.4864, 1.4876, 1.4583, 1.4886, 1.5637, 1.5662, 1.5680, 1.6900, 1.6901, 1.6903, 1.6906, 2.4630, 2.4631, 2.4669, 2.4816, 2.4817, 2.4851, 2.4867, 2.4870, 2.4951</p> <p>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</p> <p>UNS Nr: K81340 - N06600 - N06601 - N08800 - N08810</p> <p>Alloy 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810</p> | | | | | | | | | | |

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | Cr | Ni | Ti | Fe | Nb+Ta | Nb |
|------|-----|-----|----|----|-----|----|-------|-----|
| 0.08 | 0.8 | 8.5 | 15 | 70 | 0.5 | 5 | 2 | 1.5 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded | >360 | 600 | 34 | HRc |

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E NiCro 600

| | | | |
|-------------------------|-----------|---------|---------------|
| E NICRO 600 2,4 X 229MM | Packaging | KG/unit | EanCode |
| | Can | 2,27 | 8720663418548 |
| E NICRO 600 3,2 X 356MM | Packaging | KG/unit | EanCode |
| | Can | 2,27 | 8720663418555 |
| E NICRO 600 4,0 X 356MM | Packaging | KG/unit | EanCode |
| | Can | 2,27 | 8720663418562 |
| E NICRO 600 4,8 X 356MM | Packaging | KG/unit | EanCode |
| | Can | 2,27 | 8720663418579 |