



# CEWELD E NiCrMo 686 CPT

**TYPE** Electrode enrobée base nickel NiCrMo welding

**APPLICATIONS** CEWELD® E NiCrMo 686 CPT electrode for welding duplex, super-duplex and super-austenitic stainless steels as well as nickel alloys such as UNS N06059 and N06022, Inconel alloy C-276 and Inconel alloys 622, 625 and 686.

**PROPRIÉTÉS** CEWELD® E NiCrMo 686 CPT electrode has good corrosion resistance in pollution controlled engineering and in chemical, process, petrochemical, oil and gas, and marine industries. Useable for butt- and fillet welding in all positions for diameters 2,4 and 3,2mm. Diameters >4,0 excellent in downhand position.

**CLASSIFICATION**

AWS	A 5.11: E NiCrMo-14
EN ISO	14172: E Ni 6686 (NiCr21Mo16W4)
W.Nr.	~ 2.4606
F-nr	43
FM	6

**CONVIENT POUR** Joining Duplex, Superduplex, super austenitic stainless steel, nickel Alloys, N06059, N06022, Hastelloy C276, Alloy C22, Inconel 622, 625, 686, chemical and petrochemical industry, 2.4605, 2.4610, 2.4602, 2.4819, NiCr23Mo16Al, NiMo16Cr15Ti, NiCr21Mo14W, NiMo16Cr15W, alloy 59, alloy C4, alloy 276

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



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

C	Si	Mn	Cr	Ni	Mo	Fe	W	Cu
0.01	0.18	0.8	22	55	16	4	3.8	0.35

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	RP0,2 (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	380	740	34	HRc

**ETUVAGE** 300°C / 2 hr

**GAS ACC. EN ISO 14175**



# CEWELD E NiCrMo 686 CPT

E NICKRMO 686 CPT 2,4 X  
229MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419453

E NICKRMO 686 CPT 3,2 X  
356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419460

E NICKRMO 686 CPT 4,0 X  
356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419477