



CEWELD Nicro 602 CA Tig

TYPE	Nickel based filler metal against extreme temperature conditions.																
ANWENDUNGEN	Welding similar alloys that have to resist extreme high temperature and for cladding steels or stainless steels to obtain a high temperature resistant surface against oxidation.																
EIGENSCHAFTEN	Excellent welding properties with high build-up capacity and low dilution rate. Excellent resistance against temperature cycling conditions up to 1200°C and carburized medias. Excellent fatigue strength and creep properties.																
KLASSIFIKATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCrFe-12</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 6025(NiCr25Fe10AlY)</td> </tr> <tr> <td>W.Nr.</td> <td>2.4649</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.14: ERNiCrFe-12	EN ISO	18274: S Ni 6025(NiCr25Fe10AlY)	W.Nr.	2.4649	F-nr	43	FM	6						
AWS	A 5.14: ERNiCrFe-12																
EN ISO	18274: S Ni 6025(NiCr25Fe10AlY)																
W.Nr.	2.4649																
F-nr	43																
FM	6																
GEEIGNET FÜR	Cladding against high temperature, radiant heater tubes, furnace rolls, muffles in bright annealing furnaces (H2 atmosphere), rotary kilns, pipe hangers, waste gas components, hydrogen production, methanol and ammonia synthesis, 1.4767, 2.4633, 2.4649, NiCr25FeAlY, Nicrofer 6025 HT, Alloy 602CA, UNS N06025, Centralloy HTE																
ZULASSUNGEN																	
SCHWEISSPOSITIONEN																	
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>Ti</th> <th>Fe</th> <th>Al</th> </tr> </thead> <tbody> <tr> <td>0.2</td> <td>0.4</td> <td>0.4</td> <td>25</td> <td>65</td> <td>0.15</td> <td>10</td> <td>2</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Ti	Fe	Al	0.2	0.4	0.4	25	65	0.15	10	2
C	Si	Mn	Cr	Ni	Ti	Fe	Al										
0.2	0.4	0.4	25	65	0.15	10	2										
MECHANISCHE GÜTEWERTE	<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></th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>785</td> <td>959</td> <td>15</td> <td>60</td> <td></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		As Welded	785	959	15	60		HRc
Heat Treatment	R _{P0.2} (MPa)					R _m (MPa)	A ₅ (%)		Impact Energy (J) ISO-V		Hardness						
		RT															
As Welded	785	959	15	60		HRc											
RÜCKTROCKNUNG	Not required																
GAS ACC. EN ISO 14175	I1																



CEWELD Nicro 602 CA Tig

NICRO 602 CA TIG 1,6 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663418364

NICRO 602 CA TIG 2,0 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663418371

NICRO 602 CA TIG 2,4 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663418388