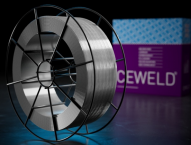




# CEWELD NiCr 600

TYPE	Solid nickel base welding wire for GMAW welding.																
ANWENDUNGEN	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.																
EIGENSCHAFTEN	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.																
KLASSIFIKATION	<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						
AWS	A 5.14: ERNiCr-3																
EN ISO	18274: S Ni 6082 (NiCr20Mn3Nb)																
W.Nr.	2.4806																
F-nr	43																
FM	6																
GEEIGNET FÜR	<p><b>E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3, Ni 6082 (NiCr20Mn3Nb)</b>            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  <b>UNS Nr:</b> K81340 - N06600 - N06601 - N08800 - N08810  <b>ASTM</b> B163, B166, B167 und B168            Alloy 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810</p>																
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>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										
0.04	0.1	2.9	20	72.5	2.4	0.4	1.3										
MECHANISCHE GÜTEWERTE	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R<sub>P0,2</sub> (MPa)</th> <th rowspan="2">R<sub>m</sub> (MPa)</th> <th rowspan="2">A<sub>5</sub> (%)</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 <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness	RT	-196°C	As Welded	420	650	35	150	100	HRC
Heat Treatment	R <sub>P0,2</sub> (MPa)					R <sub>m</sub> (MPa)	A <sub>5</sub> (%)		Impact Energy (J) ISO-V		Hardness						
		RT	-196°C														
As Welded	420	650	35	150	100	HRC											
RÜCKTROCKNUNG	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