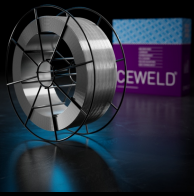


CEWELD NiCrMo 686 CPT

TYPE	Nickel-Chromium-Molybdenum based alloy for gas metal arc welding																										
APPLICATIONS	NiCrMo 686 is of great value for service environments requiring general corrosion-resistance in HCl or sulfuric acid; for resistance to crevice corrosion in hot, concentrated acid chloride solutions such as sulfur dioxide saturated NaCl solutions and oxidizing chloride solutions; and for resistance to intergranular attack, and for resistance to intergranular attack, after sensitization, in highly oxidizing environments.																										
PROPERTIES	NiCrMo 686 (UNS N06686/W.Nr. 2.4606) is a single-phase, austenitic Ni-Cr-Mo-W alloy offering outstanding corrosion-resistance in a range of severe environments. Its high nickel (Ni) and molybdenum (Mo) provide good resistance in reducing conditions, and high chromium (Cr) offers resistance to oxidizing media. Molybdenum (Mo) and tungsten (W) aid resistance to localized corrosion such as pitting. Iron (Fe) is closely controlled to enhance properties. Low carbon (C) helps minimize grain boundary precipitation to maintain corrosion-resistance in the heat-affected zones of welded joints. Resistance to general, pitting and crevice corrosion increases with the alloying (Cr+Mo+W) content, and NiCrMo 686 scores higher than competitive materials.																										
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCrMo-14</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 6686 (NiCr21Mo16W4)</td> </tr> <tr> <td>W.Nr.</td> <td>~2.4606</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.14: ERNiCrMo-14	EN ISO	18274: S Ni 6686 (NiCr21Mo16W4)	W.Nr.	~2.4606	F-nr	43	FM	6																
AWS	A 5.14: ERNiCrMo-14																										
EN ISO	18274: S Ni 6686 (NiCr21Mo16W4)																										
W.Nr.	~2.4606																										
F-nr	43																										
FM	6																										
SUITABLE FOR	<p>ENiCrMo-14, E Ni 6686 NiCr21Mo16W4 2.4602, 2.4605, 2.4607, 2.4610, 2.4819, 2.4656, 1.4529, 1.4547, 1.4565 NiCr23Mo16, NiCr23Mo16Al, NiMo16Cr15Ti, NiMo16Cr16Ti, NiCr21Mo14W, NiMo16Cr15W, NiCr22Mo9Nb, Alloy 59, Alloy C4, Alloy 276, X1NiCrMoCuN25-20-7, X1CrNiMoCuN20-18-7 ASTM: C-4, C-276, C-22, 625, 904hMo UNS: N06059, N06455, N10276, N06022, N06625, N08925, S31254 Duplex, Superduplex, super austenitic stainless steel, Nickel Alloys, N06059, N06022, Hastelloy C276, Alloy C22, Inconel 622, 625, 686, Outokumpu 654 SMO,</p>																										
APPROVALS																											
WELDING POSITIONS																											
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>P</th> <th>S</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Ti</th> <th>Fe</th> <th>W</th> <th>Cu</th> <th>Al</th> </tr> </thead> <tbody> <tr> <td>0.03</td> <td>0.06</td> <td>0.3</td> <td>0.002</td> <td>0.001</td> <td>21</td> <td>58</td> <td>16</td> <td>0.1</td> <td>0.8</td> <td>3.5</td> <td>0.01</td> <td>0.23</td> </tr> </tbody> </table>	C	Si	Mn	P	S	Cr	Ni	Mo	Ti	Fe	W	Cu	Al	0.03	0.06	0.3	0.002	0.001	21	58	16	0.1	0.8	3.5	0.01	0.23
C	Si	Mn	P	S	Cr	Ni	Mo	Ti	Fe	W	Cu	Al															
0.03	0.06	0.3	0.002	0.001	21	58	16	0.1	0.8	3.5	0.01	0.23															
MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{P0,2} (MPa)</th> <th>R_m (MPa)</th> <th>A₅ (%)</th> <th>Hardness</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td></td> <td>760</td> <td></td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness	As Welded		760		HRc																
Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness																							
As Welded		760		HRc																							
REDRYING	Not required																										
GAS ACC. EN ISO 14175	I1, I3																										



CEWELD NiCrMo 686 CPT

NICRMO 686 CPT 0,8MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663419484
NICRMO 686 CPT 1,0MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663419507
NICRMO 686 CPT 1,14MM	Packaging	KG/unit	EanCode
	BS-300	13,6	8720663419521
NICRMO 686 CPT 1,6MM	Packaging	KG/unit	EanCode
	BS-300	15	8720663419538