



# CEWELD E Alloy B3

**TYPE** Nickel based stick electrode. (Type Alloy B3, Ni1067, E NiMo-10)

**APPLICATIONS** CEWELD® E Alloy B3 is for welding Hastelloy B2, Hastelloy B3, dissimilar welding Hastelloy to nickel-iron-based corrosion alloys, for weld overlay cladding. It is used in numerous chemical process industry (CPI) applications, especially in the construction of reaction vessels for pure, reducing acid service.

**PROPERTIES** CEWELD® E Alloy B3 is a nickel-base alloy with excellent resistance to hydrochloric acid at all concentrations and temperatures. It also withstands hydrogen chloride, sulfuric, acetic, hydrofluoric and phosphoric acids. The alloy has improved thermal stability, fabricability and stress corrosion cracking resistance.

**CLASSIFICATION**

AWS	A 5.11: E NiMo-10
EN ISO	14172: Ni1067 (NiMo30Cr)
W.Nr.	2.4695
F-nr	43

**SUITABLE FOR** **Hastelloy B2, Hastelloy B3,**  
17744, 17750, 17751, 17752, 17753  
ASTM: B 333, B 335, B 564, B 619, B 622, B 626

**APPROVALS**

**WELDING POSITIONS**



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

C	Si	Mn	Cr	Ni	Mo	Fe	W	Co
0.01	0.1	1.5	2.5	68	27	1.2	1	1

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	400	700	40	120		HRc

**REDRYING** Not required

**GAS ACC.** EN ISO 14175



# CEWELD E Alloy B3

E ALLOY B3 3,2 X 355MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419897

E ALLOY B3 4,0 X 355MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419927