



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	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,
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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	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	380	740	34	HRc

ETUVAGE	300°C / 2 hr
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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