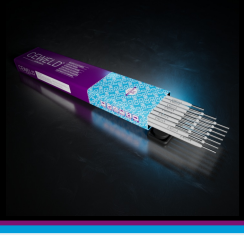


CEWELD E NiCro A

certilas® THE FILLER METAL SPECIALIST

TYPE

Nickel based high basic SMAW welding electrode.

APPLICATIONS

CEWELD® E NiCro A Welding Electrode is used for shielded-metal-arc welding of INCOLOY alloys 800 and 800HT, INCONEL alloys 600 and 601, and nickel steels.

PROPRIÉTÉS

The weld metal has excellent strength and oxidation resistance at high temperatures and retains impact resistance at cryogenic temperatures. The electrode is an exceptionally versatile product for dissimilar welding. It can be used on a variety of austenitic and ferritic steels and nickel alloys.

CLASSIFICATION

AWS	A 5.11: E NiCrFe-2
EN ISO	14172: E Ni 6092 (NiCr16Fe9NbMo)
W.Nr.	2.4805
F-nr	43
FM	6

CONVIENT POUR

E Ni 6092 (NiCr16Fe12NbMo), ENiCrFe-2
Mat No: 2.4630, 2.4631, 2.4669, 2.4694, 2.4816, 2.4817, 2.4851, 2.4867, 2.4869, 2.4870, 2.4951, 2.4952.. (1.4859, 1.4861, 1.4876, 1.4877, 1.4885, 1.4958, 1.4968, 1.5637, 1.5662, 1.5680, 16900, 1.6903, 1.6906)
NiCr15Fe, X10NiCrAlTi 32 20, G-X10NiCrNiNb 32 20, NiCr20Ti, NiCr20TiAl, X8Ni9, X7NiMo6, 12Ni19, 12Ni14
ASTM: Alloy 600, Alloy 800, Alloy 800H, Alloy 75, Alloy 80A, B163, B166, B167, B168

AGRÉMENTS

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	Nb+Ta	Nb
0.08	0.6	2.8	15	70	2	9.5	2.8	2

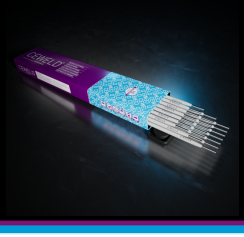
PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	420	600	40	100	80	HRc

ETUVAGE

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E NiCro A

E NICRO A 2,4 X 229MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418500

E NICRO A 3,2 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418517

E NICRO A 4,0 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418524

E NICRO A 4,8 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418531