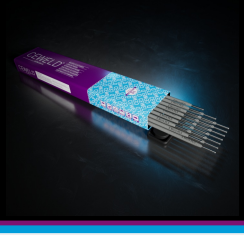


CEWELD E NiCro HLS

certilas® THE FILLER METAL SPECIALIST

TYPE

Basic coated electrode for joining and cladding. Excellent for similary and dissimilar materials and for difficult to weld steels.

APPLICATIONS

Maintenance and new welding applications in chemical, apparatus and heavy industry. First choice electrode for dissimilar welding of steel to Nickel alloys or repairing high carbon steels and white cast irons.

PROPRIÉTÉS

Extreme crack resistant weld deposit due to the special basic coating and his alloy nature. Suitable for working temperatures between -196 °C and +650 °C. Recovery 150% with excellent arc stability and easy slag removal.

CLASSIFICATION

AWS	A 5.11: E NiCrFe-3
EN ISO	14172: E Ni 6082
W.Nr.	2.4648
F-nr	~43
FM	6

CONVIENT POUR

Ni 6082 (NiCr20Mn3Nb), ENiCrFe-3
1.4429, 1.4539, 1.4583, 1.4816, 1.4876, 1.5662, 1.5680, 1.5637, 1.6582, 2.4669, 2.4806, 2.4816, 2.4851, 2.4867, 2.4951,
X10NiCrAlTi3 2 20, X10CrNiMoNb18 12,NiCr20Ti, X 2 CrNiMoN 17-12-3, X 1 NiCrMoCu 25-20-5,X 8 NiCrAlTi 32-21,
X 20 CrMoV 11-1, X 8 Ni 9, NiCr 15 Fe, NiCr 6015, NiCr 10
AISI 4340, 4130, 8630
ASTM B163, B166, B167 und B168
UNS: K 81340, N06600, N 06601, N 08800, N 08810.
Incoloy 800, DS - Inconel 600, 601, Alloy 82, Alloy 80A, Alloy X750,

AGRÉMENTS

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Fe	Nb
0.06	0.5	5	20	70	3	2.5

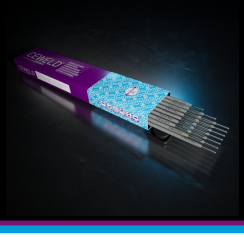
PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	400	650	35	90	70	HRc

ETUVAGE

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E NiCro HLS

certilas® THE FILLER METAL SPECIALIST

E NICRO HLS 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	3	8720663418586

E NICRO HLS 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663418593

E NICRO HLS 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,5	8720663418609

E NICRO HLS 5,0 X 350MM

Packaging	KG/unit	EanCode
Can	3.5	8720663418616