



# CEWELD Alloy B3

|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                            |                      |                    |                         |    |     |     |    |          |    |
|---------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------|----------------------|--------------------|-------------------------|----|-----|-----|----|----------|----|
| TYPE                                              | Nickel based wire or rod for welding Hastelloy B2 and B3                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                            |                      |                    |                         |    |     |     |    |          |    |
| APPLICATIONS                                      | Plants for the production and processing of hydrochloric, sulfuric, acetic and phosphoric acids. Plants for ethylbenzene production. Pressure vessels for chloroprene production. Plants for the production of phenol from isopropyl benzene. Pyrolysis plants for the production of acetic anhydride                                                                                                                                                                                                     |                            |                      |                    |                         |    |     |     |    |          |    |
| PROPERTIES                                        | CEWELD® Alloy B3 is a nickel-base alloy with excellent resistance tot hydrochlorid acid at all concentrations and tempertures. It also withstands hydrogen chloride, sulfuric, acetic, hydrofluoric nd phosphoric acids. The alloy has improved thermal stability, fabricability and stress corrosion cracking resistance.                                                                                                                                                                                |                            |                      |                    |                         |    |     |     |    |          |    |
| CLASSIFICATION                                    | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | A 5.14: ERNiMo-10          |                      |                    |                         |    |     |     |    |          |    |
|                                                   | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 18274: S Ni 1067(NiMo30Cr) |                      |                    |                         |    |     |     |    |          |    |
|                                                   | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 2.4695                     |                      |                    |                         |    |     |     |    |          |    |
|                                                   | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 43                         |                      |                    |                         |    |     |     |    |          |    |
|                                                   | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 6                          |                      |                    |                         |    |     |     |    |          |    |
| SUITABLE FOR                                      | Hastelloy B2, Hastelloy B3 oder B4, Nicrofer® 6629<br>NiMo29Cr, NiMo28<br>2.4600, 2.4617<br>UNS N 10629, N 10629, N10665<br>ASTM: B 333, B 335, B 564, B 619, B 622, B 626                                                                                                                                                                                                                                                                                                                                |                            |                      |                    |                         |    |     |     |    |          |    |
| APPROVALS                                         |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                            |                      |                    |                         |    |     |     |    |          |    |
| WELDING POSITIONS                                 | <div> PA</div> <div> PB</div> <div> PC</div> <div> PD</div> <div> PF</div> |                            |                      |                    |                         |    |     |     |    |          |    |
| TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | Si                         | Mn                   | Cr                 | Ni                      | Mo | Ti  | V   | Fe | W        | Co |
|                                                   | 0.01                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 0.08                       | 2                    | 2                  | 68                      | 28 | 0.1 | 0.1 | 2  | 2        | 2  |
| 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 |    |
|                                                   | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 544                        | 824                  | 45                 | RT                      |    |     |     |    | 195      |    |
|                                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                            |                      |                    |                         |    |     |     |    | HRc      |    |
| REDRYING                                          | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                            |                      |                    |                         |    |     |     |    |          |    |
| GAS ACC. EN ISO 14175                             | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                            |                      |                    |                         |    |     |     |    |          |    |



# CEWELD Alloy B3

ALLOY B3 0,9MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| BS-300    | 13,6    | 8720663419873 |