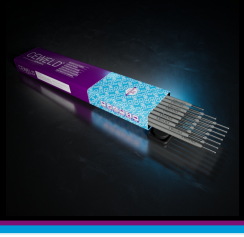


CEWELD E NiCro HLS

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. (Type E 6082, E NiCrFe3)

APPLICATIONS

CEWELD® E NiCro HLS is the electrode of choice for joint welding of steel with nickel alloys or repair of high carbon steels and white cast iron. CEWELD® E NiCro HLS is suitable for maintenance and new welds in the chemical, apparatus and heavy industry, furnace repair, unknown steel, cock wheels, chains. As well as for welding mixed joints with Inconel, Hasteloy, Nimonic, stainless steel and difficult-to-weld steel

PROPERTIES

CEWELD® E NiCro HLS has an extremely crack-resistant weld metal due to the special basic coating and its alloy properties. Suitable for working temperatures between -196 °C and +650 °C. The yield is 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

SUITABLE FOR

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,

APPROVALS

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

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

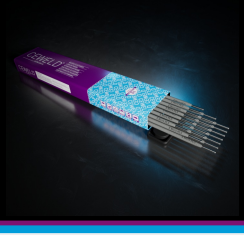
MECHANICAL PROPERTIES

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

REDRYING

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