



CEWELD NiCro 600 Tig

TYPE Solid nickel base welding wire for gas tungsten arc welding (GTAW).

APPLICATIONS CEWELD NiCro 600 filler metal is used for welding nickel-chromium-iron (Inconel 600, 601 and 690) alloys to themselves, and for dissimilar welding between nickel-chromium-iron (Monel, Inconel and Incoloy) alloys and steels or stainless steels. The applications include surfacing as well as clad-side welding.

PROPERTIES High manganese of this weld deposit reduces the possibility of micro fissures. High toughness at low temperatures (-269 °C). Heat- and high temperature resistant. Good resistance to hotcracking. Temperature limits: 900 °C max.

CLASSIFICATION

AWS	A 5.14: ERNiCr-3
EN ISO	18274: S Ni 6082 (NiCr20Mn3Nb)
W.Nr.	2.4806
F-nr	43
FM	6

SUITABLE FOR **E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3, Ni 6082 (NiCr20Mn3Nb)**
 2.4630, 2.4631, 2.4669, 2.4816, 2.4817, 2.4851, 2.4867, 2.4870, 2.4951 ... (1.4816, 1.4864, 1.4876, 1.4583, 1.4886, 1.5637, 1.5662, 1.5680, 1.6900, 1.6901, 1.6903, 1.6906)
 NiCr20Ti, NiCr21TiAl, NiCr15Fe7TiAl, NiCr15Fe, LC-NiCr15Fe, NiCr23Fe, NiCr60 15, NiCr80 20, NiCr 10, NiCr20Ti 1.5637 12 Ni 14, X8Ni9, 12Ni19, X12CrNi18 9, GX8CrNi18 10, X10CrNiTi18 10, X5CrNi18 10
UNS Nr: K81340 - N06600 - N06601 - N08800 - N08810
ASTM B163, B166, B167 und B168
 Alloy 330, Alloy 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Nb	Ti	Fe
0.04	0.11	2.9	20.2	72.3	2.3	0.36	1.3

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	420	650	35	200	100	HRC

REDRYING Not required

GAS ACC. EN ISO 14175 11



CEWELD NiCro 600 Tig

NICRO 600 TIG 1,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663418128
NICRO 600 TIG 1,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663418135
NICRO 600 TIG 1,6 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663418159
NICRO 600 TIG 1,6 X 914MM	Packaging	KG/unit	EanCode
	Tube	4,54	8720663418142
NICRO 600 TIG 2,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663418173
NICRO 600 TIG 2,0 X 914MM	Packaging	KG/unit	EanCode
	Tube	4,54	8720663418166
NICRO 600 TIG 2,4 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663418197
NICRO 600 TIG 2,4 X 914MM	Packaging	KG/unit	EanCode
	Tube	4,54	8720663418180
NICRO 600 TIG 3,2 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663418203
NICRO 600 TIG 3,2 X 914MM	Packaging	KG/unit	EanCode
	Tube	4,54	8720663418210
NICRO 600 TIG 4,0 X 1000MM	Packaging	KG/unit	EanCode
	Tube	5	8720663418227