



CEWELD E NiCr 690

TYPE	Nickel based high basic SMAW welding electrode. (Type Alloy 690)							
APPLICATIONS	CEWELD E NiCro 690 electrodes are used for welding of nickel-chromium-iron Inconel alloys 690 to themselves and 600 steels. Also for heterogeneous stainless and low-alloy steels. Soft arc, easily detachable slag, regular beads. Nuclear power plants, chemical industry.							
PROPERTIES	CEWELD E NiCro 690 has a higher Cr content which improves resistance to stress-corrosion cracking in the nuclear, pure water enviroment.							
CLASSIFICATION	AWS	A 5.11: ENiCrFe-7						
	EN ISO	14172: Ni 6152 NiCr30Fe9Nb						
	F-nr	43						
	FM	6						
SUITABLE FOR	Alloy 690, UNS W86152, NiCrFe-7 Inconel 690, VDM Alloy 690, Nicrofer 6030 N, FM 52, 2.4642, NiCr29Fe, Inconel 600, NiCr30Fe9Nb							
APPROVALS								
WELDING POSITIONS	  							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo	Nb	Fe
	0.04	0.5	4	29	Rem.	0.3	1.5	7
MECHANICAL PROPERTIES	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	
					RT			
	As Welded	430	650	40	110		HRc	
REDRYING	Not required							
GAS ACC. EN ISO 14175								