


CEWELD SA Nicro 600

TYPE	Nickel - Chromium alloy for SAW wire.																
APPLICATIONS	CEWELD® SA Nicro 600 filler metal is used for SAW 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	CEWELD® SA Nicro 600 is a solid drawn wire to be used for the submerged arc process in combination with our fused flux CEWELD® FL 880 or agglomerated flux CEWELD® FL 838.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCr-3</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 6082 (NiCr20Mn3Nb)</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> <tr> <td>W.Nr.</td> <td>2.4806</td> </tr> </table>	AWS	A 5.14: ERNiCr-3	EN ISO	18274: S Ni 6082 (NiCr20Mn3Nb)	F-nr	43	FM	6	W.Nr.	2.4806						
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SUITABLE FOR	<p>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 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810</p>																
APPROVALS	No Approvals Found																
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Nb</th> <th>Ti</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.3</td> <td>3</td> <td>20</td> <td>70</td> <td>2.8</td> <td>0.4</td> <td>2</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Nb	Ti	Fe	0.08	0.3	3	20	70	2.8	0.4	2
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As Welded /	440	550	33	70	70												
REDRYING TEMPERATURE	Not required																
GAS ACCORDING EN 14175																	



CEWELD SA Nicro 600

SA NICRO 600 2,4MM

Type	KG/unit	EANCode
K-415	25	8720663418470

SA NICRO 600 3,2MM

Type	KG/unit	EANCode
K-415	25	8720663418487