



CEWELD E NiCrO A

TYPE Nickel based high basic SMAW welding electrode. (Type E NiCrFe-2, E Ni 6092)

APPLICATIONS **CEWELD® E NiCrO A** electrodes are used for welding Incoloy alloys 800 and 800HT, Inconel 600 and 601 and nickel alloys. Examples include combinations of stainless steels, carbon steels, INCONEL alloys, INCOLOY alloys, MONEL alloys and copper-nickel alloys. Due to its versatility, it is particularly useful for general maintenance welding on equipment exposed to harsh operating conditions.

PROPERTIES The weld metal of **CEWELD® E NiCrO A** has excellent strength and oxidation resistance at high temperatures and retains its impact strength at low temperatures. The electrode is exceptionally versatile for dissimilar joint welding. It can be used on a wide range of austenitic and ferritic steels and nickel alloys.

CLASSIFICATION	AWS	A 5.11: E NiCrFe-2
	EN ISO	14172: E Ni 6092 (NiCr16Fe9NbMo)
	F-nr	43
	FM	6
	W.Nr.	2.4805

SUITABLE FOR **E Ni 6092 (NiCr16Fe12NbMo), ENiCrFe-2**
Mat No: 2.4630, 2.4631, 2.4669, 2.4694, 2.4816, 2.4817, 2.4851, 2.4867, 2.4869, 2.4870, 2.4951, 2.4952.. (1.4859, 1.4861, 1.4876, 1.4877, 1.4885, 1.4958, 1.4968, 1.5637, 1.5662, 1.5680, 16900, 1.6903, 1.6906)
NiCr15Fe, X10NiCrAlTi 32 20, G-X10NiCrNiNb 32 20, NiCr20Ti, NiCr20TiAl, X8Ni9, X7NiMo6, 12Ni19, 12Ni14
ASTM: Alloy 600, Alloy 800, Alloy 800H, Alloy 75, Alloy 80A, B163, B166, B167, B168

APPROVALS No Approvals Found

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	Nb+Ta	Nb
0.08	0.6	2.8	15	70	2	9.5	2.8	2

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V RT	-196°C
As Welded /	420	600	40	100	80

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175



CEWELD E NiCro A

E Nicro A 2,4 X 229MM

Type	KG/unit	EANCode
Can	2,27	8720663418500

E Nicro A 3,2 X 356MM

Type	KG/unit	EANCode
Can	2,27	8720663418517

E Nicro A 4,0 X 356MM

Type	KG/unit	EANCode
Can	2,27	8720663418524

E Nicro A 4,8 X 356MM

Type	KG/unit	EANCode
Can	2,27	8720663418531