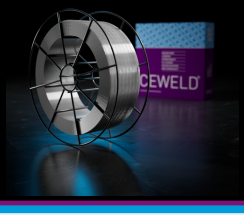


certilas® THE FILLER METAL SPECIALIST

CEWELD NiCro 602 CA

TYPE

Nickel based filler metal against extreme temperature conditions.

APPLICATIONS

Welding similar alloys that have to resist extreme high temperature and for cladding steels or stainless steels to obtain a high temperature resistant surface against oxidation.

PROPERTIES

Excellent welding properties with high build-up capacity and low dilution rate. Excellent resistance against temperature cycling conditions up to 1200°C and carburized medias. Excellent fatigue strength and creep properties.

CLASSIFICATION

AWS	A 5.14: ERNiCrFe-12
EN ISO	18274: S Ni 6025(NiCr25Fe10AlY)
F-nr	43
FM	6
W.Nr.	2.4649

SUITABLE FOR

Cladding against high temperature, radiant heater tubes, furnace rolls, muffles in bright annealing furnaces (H2 atmosphere), rotary kilns, pipe hangers, waste gas components, hydrogen production, methanol and ammonia synthesis, 2.4633, 2.4649, NiCr25FeAlY, Nicrofer 6025 HT, Alloy 602CA, UNS N06025, Centralloy HTE

APPROVALS

No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Ti	Fe	Al
0.2	0.4	0.4	25	65	0.15	10	2

ALL WELD MECHANICAL PROPERTIES

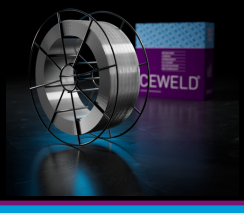
Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT
As Welded /	520	750	26	50

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

I1



CEWELD NiCro 602 CA

NICRO 602 CA 1,0MM

Type	KG/unit	EANCode
BS-300	15	8720663418333

NICRO 602 CA 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663418340

NICRO 602 CA 1,6MM

Type	KG/unit	EANCode
BS-300	10,9	8720663418357