




# CEWELD AA NiCrO 600B

TYPE	Basic flux-cored nickel base welding wire for gas shielded arc welding.																
APPLICATIONS	AA NICRO 600B is developed for welding and cladding nickel-based alloys such as alloy 600 or similar materials. This alloy can also be used for welding dissimilar nickel-based alloys to each other, to alloyed steels or to stainless steels. AA NICRO 600B can also be used on difficult to weld steels !																
PROPERTIES	Latest generation basic slag quality guarantees optimum metallurgical quality and attractive welder appeal. The weld deposit meets the NiCrFe-3 requirements. Better bead aspect and shape compare to solid wires with better arc stability and improved wetting properties with less spatters. Excellent results are also achieved without protective gas.																
CLASSIFICATION	<table border="0"> <tr> <td>EN ISO</td> <td>12153-A: T Ni 6082 (NiCr15Fe6Mn) R M21 3</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>2.4648</td> </tr> </table>	EN ISO	12153-A: T Ni 6082 (NiCr15Fe6Mn) R M21 3	F-nr	43	FM	6	W.Nr.	2.4648								
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SUITABLE FOR	<p><b>E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3, Ni6082</b>            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  <b>UNS Nr:</b> K81340 - N06600 - N06601 - N08800 - N08810  <b>ASTM</b> 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 WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Nb</th> <th>Fe</th> <th>S</th> </tr> </thead> <tbody> <tr> <td>0.01</td> <td>0.3</td> <td>5</td> <td>16.5</td> <td>Rem.</td> <td>1.7</td> <td>6</td> <td>0.015</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Nb	Fe	S	0.01	0.3	5	16.5	Rem.	1.7	6	0.015
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REDRYING TEMPERATURE	140°C / 24 hr																
GAS ACCORDING EN 14175	M21																