



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 12153-A: T Ni 6082 (NiCr15Fe6Mn) R M21 3

F-nr 43 FΜ 6 W.Nr. 2.4806

SUITABLE FOR E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3, Ni6082

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

APPROVALS No Approvals Found

WELDING POSITIONS



TYPICAL CHEMICAL ΔN

(%

ALYSIS OF WELD METAL	_
)	

С	Si	Mn	Cr	Ni	Nb	Fe	S
0.01	0.3	5	16.5	Rem.	1.7	6	0.015

ALL WELD MECHANICAL **PROPERTIES**

Heat	$R_{P0,2}$	Rm	A5	Impact Energy (J) ISO-V
Treatment	MPa	MPa	(%)	-196°C
As Welded /	390	610	45	90

REDRYING TEMPERATURE 140°C / 24 hr

GAS ACCORDING EN 14175 M21