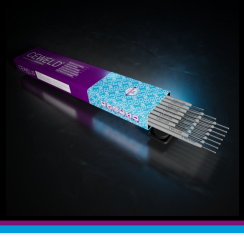


# CEWELD E NiCro 600

certilas® THE FILLER METAL SPECIALIST

**TYPE**

High basic nickel-based stick electrode for welding. (Type E Ni 6182, E NiCrFe-3)

**APPLICATIONS**

**CEWELD® E NiCro 600** is used for welding nickel-chromium-iron alloys (Inconel 600, 601 and 690) to themselves and for dissimilar welds between nickel-chromium-iron alloys (Monel, Inconel and Incoloy) and steels or stainless steels. Applications include both build-up welding and clad side welding, welding of heat resistant alloys in furnaces, dissimilar welding between nickel-based alloys (including Monel) and stainless steels, low alloy steels and carbon steels.

**PROPERTIES**

The high manganese content of this **CEWELD® E NiCro 600** weld metal reduces the possibility of microcracks. High mechanical properties with excellent thermal shock resistance and notched impact strength at sub-zero temperatures down to -196 °C.

**CLASSIFICATION**

| | |
|---|---|
| AWS | A 5.11: E NiCrFe-3 |
| EN ISO | 14172: E Ni 6182 |
| F-nr | 43 |
| FM | 6 |
| W.Nr. | 2.4807 |

**SUITABLE FOR**

**E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3**
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 ANALYSIS OF WELD METAL (%)**

| C | Si | Mn | Cr | Ni | Ti | Fe | Nb+Ta | Nb |
|---|---|---|---|---|---|---|---|---|
| 0.08 | 0.8 | 8.5 | 15 | 70 | 0.5 | 5 | 2 | 1.5 |

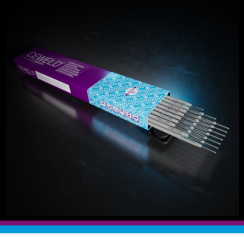
**ALL WELD MECHANICAL PROPERTIES**

| Heat Treatment | $R_{P0,2}$ MPa | Rm MPa | A5 (%) |
|---|---|---|---|
| As Welded / | | 600 | 34 |

**REDRYING TEMPERATURE**

300°C / 2 hr

**GAS ACCORDING EN 14175**



# CEWELD E NiCro 600

certilas® THE FILLER METAL SPECIALIST

| E NICRO 600 2,4 X 229MM | Type | KG/unit | EANCode |
|---|---|---|---|
| | Can | 2,27 | 8720663418548 |

| E NICRO 600 3,2 X 356MM | Type | KG/unit | EANCode |
|---|---|---|---|
| | Can | 2,27 | 8720663418555 |

| E NICRO 600 4,0 X 356MM | Type | KG/unit | EANCode |
|---|---|---|---|
| | Can | 2,27 | 8720663418562 |

| E NICRO 600 4,8 X 356MM | Type | KG/unit | EANCode |
|---|---|---|---|
| | Can | 2,27 | 8720663418579 |