




CEWELD E NiCr 600

TYPE	High basic nickel-based stick electrode for welding. (Type E Ni 6182, E NiCrFe-3)																		
APPLICATIONS	CEWELD® E NiCr 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 NiCr 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	<table border="0"> <tr> <td>AWS</td> <td>A 5.11: E NiCrFe-3</td> </tr> <tr> <td>EN ISO</td> <td>14172: E Ni 6182</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>2.4807</td> </tr> </table>	AWS	A 5.11: E NiCrFe-3	EN ISO	14172: E Ni 6182	F-nr	43	FM	6	W.Nr.	2.4807								
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EN ISO	14172: E Ni 6182																		
F-nr	43																		
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W.Nr.	2.4807																		
SUITABLE FOR	<p>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</p>																		
APPROVALS	No Approvals Found																		
WELDING POSITIONS																			
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Ti</th> <th>Fe</th> <th>Nb+Ta</th> <th>Nb</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.8</td> <td>8.5</td> <td>15</td> <td>70</td> <td>0.5</td> <td>5</td> <td>2</td> <td>1.5</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Ti	Fe	Nb+Ta	Nb	0.08	0.8	8.5	15	70	0.5	5	2	1.5
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>Heat Treatment</th> <th>R_{p0,2} MPa</th> <th>R_m MPa</th> <th>A₅ (%)</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td></td> <td>600</td> <td>34</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	As Welded /		600	34										
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As Welded /		600	34																
REDRYING TEMPERATURE	300°C / 2 hr																		
GAS ACCORDING EN 14175																			



CEWELD E NiCro 600

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