




CEWELD E NiCrO 690

TYPE	Nickel based high basic SMAW welding electrode. (Type Alloy 690)																
APPLICATIONS	CEWELD E NiCrO 690 electrodes are used for welding of nickel-chromium-iron Inconel alloys 690 to themselves and 600 steels. Also for heterogeneous stainless and low-alloy steels. Soft arc, easily detachable slag, regular beads. Nuclear power plants, chemical industry.																
PROPERTIES	CEWELD E NiCrO 690 has a higher Cr content which improves resistance to stress-corrosion cracking in the nuclear, pure water environment.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.11: ENiCrFe-7</td> </tr> <tr> <td>EN ISO</td> <td>14172: Ni 6152 NiCr30Fe9Nb</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.11: ENiCrFe-7	EN ISO	14172: Ni 6152 NiCr30Fe9Nb	F-nr	43	FM	6								
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SUITABLE FOR	Alloy 690, UNS W86152, NiCrFe-7 Inconel 690, VDM Alloy 690, Nicrofer 6030 N, FM 52, 2.4642, NiCr29Fe, Inconel 600, NiCr30Fe9Nb																
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>Mo</th> <th>Nb</th> <th>Fe</th> </tr> </thead> <tbody> <tr> <td>0.04</td> <td>0.5</td> <td>4</td> <td>29</td> <td>Rem.</td> <td>0.3</td> <td>1.5</td> <td>7</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	Nb	Fe	0.04	0.5	4	29	Rem.	0.3	1.5	7
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{P0,2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th colspan="2">RT</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>430</td> <td>650</td> <td>40</td> <td colspan="2">110</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		RT		As Welded /	430	650	40	110			
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REDRYING TEMPERATURE	Not required																
GAS ACCORDING EN 14175																	