



# CEWELD NiCro 600 Tig

**TYPE** Solid nickel base welding wire for gas tungsten arc welding (GTAW).

**ANWENDUNGEN** CEWELD NiCro 600 filler metal is used for welding nickel-chromium-iron (Inconel 600, 601 and 690) alloys to themselves, and for dissimilar welding between nickel-chromium-iron (Monel, Inconel and Incoloy) alloys and steels or stainless steels. The applications include surfacing as well as clad-side welding.

**EIGENSCHAFTEN** High manganese of this weld deposit reduces the possibility of micro fissures. High toughness at low temperatures (-269 °C). Heat- and high temperature resistant. Good resistance to hotcracking. Temperature limits: 900 °C max.

**KLASSIFIKATION**

|        |                                |
|--------|--------------------------------|
| AWS    | A 5.14: ERNiCr-3               |
| EN ISO | 18274: S Ni 6082 (NiCr20Mn3Nb) |
| W.Nr.  | 2.4806                         |
| F-nr   | 43                             |
| FM     | 6                              |

**GEEIGNET FÜR** **E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3, Ni 6082 (NiCr20Mn3Nb)**  
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 330, Alloy 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810

**ZULASSUNGEN**

**SCHWEISSPOSITIONEN**



**TYPISCHE CHEMISCHE  
ANALYSE DES  
FÜLLMETALLS (%)**

| C    | Si   | Mn  | Cr   | Ni   | Nb  | Ti   | Fe  |
|------|------|-----|------|------|-----|------|-----|
| 0.04 | 0.11 | 2.9 | 20.2 | 72.3 | 2.3 | 0.36 | 1.3 |

**MECHANISCHE GÜTEWERTE**

| Heat Treatment | R <sub>p0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
|                |                         |                      |                    | RT                      | -196°C |          |
| As Welded      | 420                     | 650                  | 35                 | 200                     | 100    | HRc      |

**RÜCKTROCKNUNG** Not required

**GAS ACC. EN ISO 14175** 11



# CEWELD NiCro 600 Tig

|                            |           |         |               |
|----------------------------|-----------|---------|---------------|
| NICRO 600 TIG 1,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                            | Tube      | 5       | 8720663418128 |
| NICRO 600 TIG 1,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                            | Tube      | 5       | 8720663418135 |
| NICRO 600 TIG 1,6 X 1000MM | Packaging | KG/unit | EanCode       |
|                            | Tube      | 5       | 8720663418159 |
| NICRO 600 TIG 1,6 X 914MM  | Packaging | KG/unit | EanCode       |
|                            | Tube      | 4,54    | 8720663418142 |
| NICRO 600 TIG 2,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                            | Tube      | 5       | 8720663418173 |
| NICRO 600 TIG 2,0 X 914MM  | Packaging | KG/unit | EanCode       |
|                            | Tube      | 4,54    | 8720663418166 |
| NICRO 600 TIG 2,4 X 1000MM | Packaging | KG/unit | EanCode       |
|                            | Tube      | 5       | 8720663418197 |
| NICRO 600 TIG 2,4 X 914MM  | Packaging | KG/unit | EanCode       |
|                            | Tube      | 4,54    | 8720663418180 |
| NICRO 600 TIG 3,2 X 1000MM | Packaging | KG/unit | EanCode       |
|                            | Tube      | 5       | 8720663418203 |
| NICRO 600 TIG 3,2 X 914MM  | Packaging | KG/unit | EanCode       |
|                            | Tube      | 4,54    | 8720663418210 |
| NICRO 600 TIG 4,0 X 1000MM | Packaging | KG/unit | EanCode       |
|                            | Tube      | 5       | 8720663418227 |