

# CEWELD Alloy 230

**TYPE** Nickel based Mig filler metal for welding similar NiCrW alloys.

**APPLICATIONS** In the chemical process industry, CEWELD® Alloy 230 is used for catalyst grid supports in ammonia burners, high-strength thermocouple protection tubes, high-temperature heat exchangers, ducts, high-temperature bellows, and various other key process internals. In the industrial heating industry, applications for 230 alloy include furnace retorts, chains and fixtures, burner flame shrouds, recuperator internals, dampers, nitriding furnace internals, heat-treating baskets, grates, trays, sparger tubes, thermocouple protection tubes, cyclone internals, and many more.

**PROPERTIES** CEWELD® Alloy 230 combines properties which make it ideally suited for a wide variety of component applications in the aerospace and power industries. It is used for combustion cans, transition ducts, flame holders, thermocouple sheaths, and other important gas turbine components.

**CLASSIFICATION**

|        |                                |
|--------|--------------------------------|
| AWS    | A 5.14: ERNiCrWMo-1            |
| EN ISO | 18274: S Ni 6231(NiCr22W14Mo2) |
| W.Nr.  | 2.4733                         |
| F-nr   | 43                             |
| FM     | 6                              |

**SUITABLE FOR**

**UNS-Nummer: N06230**  
 Haynes Alloy 230,  
 ASTM: B435, B564, B572, B619, B622, B626, B366, 5981  
 AMS: 5878, 5839  
 Haynes 25 alloy

**APPROVALS** CE

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C   | Si  | Mn  | Cr | Ni | Mo | W  | Co | Al  |
|-----|-----|-----|----|----|----|----|----|-----|
| 0.1 | 0.4 | 0.5 | 22 | 57 | 2  | 14 | 4  | 0.3 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      | 490                     | 780                  | 45                 | HRc      |

**REDRYING** Not required

**GAS ACC. EN ISO 14175** I1