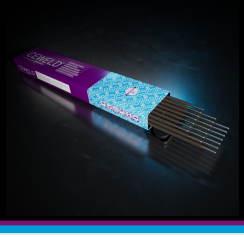

CEWELD E NiCro 690

certilas® THE FILLER METAL SPECIALIST

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 enviroment.

CLASSIFICATION

AWS	A 5.11: ENiCrFe-7
EN ISO	14172: Ni 6152 NiCr30Fe9Nb
F-nr	43
FM	6

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

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Nb	Fe
0.04	0.5	4	29	Rem.	0.3	1.5	7

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	430	650	40	110	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175