



# CEWELD E NiCrO HLS

**TYPE** Basic coated electrode for joining and cladding. Excellent for similiary and dissimilar materials and for difficult to weld steels.

**APPLICATIONS** Maintenance and new welding applications in chemical, apparatus and heavy industry. First choice electrode for dissimilar welding of steel to Nickel alloys or repairing high carbon steels and white cast irons.

**PROPRIÉTÉS** Extreme crack resistant weld deposit due to the special basic coating and his alloy nature. Suitable for working temperatures between -196 °C and +650 °C. Recovery 150% with excellent arc stability and easy slag removal.

**CLASSIFICATION**

|        |                    |
|--------|--------------------|
| AWS    | A 5.11: E NiCrFe-3 |
| EN ISO | 14172: E Ni 6082   |
| W.Nr.  | 2.4648             |
| F-nr   | ~43                |
| FM     | 6                  |

**CONVIENT POUR** **Ni 6082 (NiCr20Mn3Nb), ENiCrFe-3**  
 1.4429, 1.4539, 1.4583, 1.4816, 1.4876, 1.5662, 1.5680, 1.5637, 1.6582, 2.4669, 2.4806, 2.4816, 2.4851, 2.4867, 2.4951,  
 X10NiCrAlTi3 2 20, X10CrNiMoNb18 12, NiCr20Ti, X 2 CrNiMoN 17-12-3, X 1 NiCrMoCu 25-20-5, X 8 NiCrAlTi 32-21,  
 X 20 CrMoV 11-1, X 8 Ni 9, NiCr 15 Fe, NiCr 6015, NiCr 10  
**AISI** 4340, 4130, 8630  
**ASTM** B163, B166, B167 und B168  
**UNS:** K 81340, N06600, N 06601, N 08800, N 08810.  
 Incoloy 800, DS - Inconel 600, 601, Alloy 82, Alloy 80A, Alloy X750,

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



**ANALYSE CHIMIQUE**  
**TYPIQUE DU MÉTAL DE**  
**SOUDURE (%)**

| C    | Si  | Mn | Cr | Ni | Fe | Nb  |
|------|-----|----|----|----|----|-----|
| 0.06 | 0.5 | 5  | 20 | 70 | 3  | 2.5 |

**PROPRIÉTÉS MÉCANIQUES**

| 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      | 400                     | 650                  | 35                 | 90                      | 70     | HRc      |

**ETUVAGE** 300°C / 2 hr

**GAS ACC. EN ISO 14175**



# CEWELD E NiCro HLS

E NICRO HLS 2,5 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 3       | 8720663418586 |

E NICRO HLS 3,2 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,8     | 8720663418593 |

E NICRO HLS 4,0 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,5     | 8720663418609 |

E NICRO HLS 5,0 X 350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 3.5     | 8720663418616 |