

# CEWELD Alloy 230

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                |                         |    |                      |    |        |          |     |
|---------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------------------------|-------------------------|----|----------------------|----|--------|----------|-----|
| TYPE                                        | Nickel based Mig filler metal for welding similar NiCrW alloys.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           |                                |                         |    |                      |    |        |          |     |
| TOEPASSINGEN                                | 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. |                                |                         |    |                      |    |        |          |     |
| EIGENSCHAPPEN                               | 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.                                                                                                                                                                                                                                                                                                 |                                |                         |    |                      |    |        |          |     |
| CLASSIFICATIE                               | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       | A 5.14: ERNiCrWMo-1            |                         |    |                      |    |        |          |     |
|                                             | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 18274: S Ni 6231(NiCr22W14Mo2) |                         |    |                      |    |        |          |     |
|                                             | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 2.4733                         |                         |    |                      |    |        |          |     |
|                                             | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 43                             |                         |    |                      |    |        |          |     |
|                                             | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        | 6                              |                         |    |                      |    |        |          |     |
| GESCHIKT VOOR                               | <b>UNS-Nummer: N06230</b><br>Haynes Alloy 230,<br>ASTM: B435, B564, B572, B619, B622, B626, B366, 5981<br>AMS: 5878, 5839<br>Haynes 25 alloy                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                |                         |    |                      |    |        |          |     |
| GOEDKEURINGEN                               | CE                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                |                         |    |                      |    |        |          |     |
| LASPOSITIES                                 | <div> PA</div> <div> PB</div> <div> PC</div>                                                                                                                                                                                                                                                                                     |                                |                         |    |                      |    |        |          |     |
| 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 |
| MECHANISCHE WAARDEN                         | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                | R <sub>P0,2</sub> (MPa) |    | R <sub>m</sub> (MPa) |    | A5 (%) | Hardness |     |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                | 490                     |    | 780                  |    | 45     | HRc      |     |
| HERDROGEN                                   | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                |                         |    |                      |    |        |          |     |
| GAS ACC. EN ISO 14175                       | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                |                         |    |                      |    |        |          |     |