

## SA Nicro 602 CA (6025HT) strip

CATEGORY	ESAW Electroslag	
TYPE	Nickel based strip against extreme temperature conditions.	
APPLICATIONS	Electro slag cladding jobs that have to resist extreme high temperature and for cladding steels or stainless steels to obtain a high temperature resistant surface against oxidation.	
PROPERTIES	Excellent welding properties with high buildup capacity and low dilution rate when combined with <a href="#">FL 860 ESHC</a> . Excellent resistance against temperature cycling conditions upto 1200°C and carburized medias. Excellent fatigue strenght and creep properties.	
CLASSIFICATION	AWS	A 5.14: ER NiCrFe-12
	EN ISO	18274: S Ni6704 (NiCr25FeAl3YC)
	DIN: W.Nr.	2.4649
	DIN	1736: NiCr25FeAl
SUITABLE FOR	Cladding against high temperature, radiant heater tubes, furnace rolls, muffles in bright annealing furnaces (H <sub>2</sub> atmosphere), rotary kilns, waste gas components, hydrogen production, methanol and ammonia synthesis, 2.4633, NiCr25FeAlY, Nicrofer 6025 HT.	
APPROVALS	CE approved	

### WELDING POSITIONS:



### METAL ANALYSIS % (TYPICAL VALUES)

	C	Cr	Ni	Mn	Si	Ti	Fe	Al	Zr	Y
strip	0.18	25.30	62.14	0.08	0.04	0.13	9.58	2.23	0.06	0.08
1 layer	0.18	24	59	0.88	0.67	0.07	12	1,85	lod	lod
2 layer	0.18	25	61	0.67	0.77	0.06	10	1,97	lod	lod

Welded on mild steel / Deposit result is dependent on travel speed (S) and should be tested before final welding in order to obtain the requested results.

### MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	RT	Impact Energy (J) ISO-V		Hardness HRc / HV
					-40°C	-60°C	
as welded	520	750	26	>60			

### WELDING PARAMETERS / PACKING

Sizes	Welding Parameters			Packing	
	Voltage (V)	Current (A)	Travel speed (cm/min)	coil size	coil weight
30 x 0.5	24	500-625	18-26	550 mm	25-50
60 x 0,5	24	1000-1300	18-26	550 mm	50-75

**REDRYING TEMPERATURE** not required

**FLUX TYPE** FL 830 ESHC shall be used.