

AA NiCro 600B

CATEGORY FCAW Flux-Cored

TYPE Basic flux-cored nickel base welding wire for gas shielded arc welding.

APPLICATIONS AA NICRO 600B is developed for welding and cladding nickel-based alloys such as alloy 600 or similar materials. This alloy can also be used for welding dissimilar nickel-based alloys to each other, to alloyed steels or to stainless steels. AA NICRO 600B can also be used on difficult to weld steels !

PROPERTIES Latest generation basic slag quality guarantees optimum metallurgical quality and attractive welder appeal. The weld deposit meets the NiCrFe-3 requirements. Better bead aspect and shape compare to solid wires with better arc stability and improved wetting properties with less spatters. Excellent results are also achieved without protective gas.

CLASSIFICATION

AWS	A 5.34: E NiCr3 T 0-4
EN ISO	12153 T Ni 6082 R M21 3
DIN: W.Nr.	2.4648

SUITABLE FOR Alloy type : Incoloy 800, DS - Inconel 600, 601, UNS Nr (unified numbering system) : K 81340, N06600, N 06601, N 08800, N 08810. DIN design : X8Ni9 - 12Ni19 - 10Ni 14 - NiCr15Fe - NiCr23Fe - X10NiCrAlTi3220 - X10CrNiMoNb18.12 - NiCr20Ti. Mat n° : 1.5662 - 1.5680 - 1.5637 - 1.4876 - 1.4583 - 2.4816 - 2.4851 - 2.4951, 2.4806, Alloy 82, 1.4816, 600L, 800H, difficult to Weld steel, chain, cock wheels, kiln tyre

APPROVALS CE approved

WELDING POSITIONS:



ALL-WELD METAL ANALYSES %

C	Mn	Si	Cr	Ni	Nb	Fe
0.01	6.0	0.3	17.0	bal	1.7	6.0

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-196°C	
AW	380	610	45			90	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	Spools	kg/spool	kg/pallet
1.2	24-32	130-250	K-300	15	1080
1.6	24-32	150-300	K-300	15	1080

REDRYING TEMPERATURE 150°C / 24hr

GAS ACC.EN ISO 14175: M21