CEWELD®

Nicro 602 CA Tig (6025HT)

CATEGORY	GMAW-GTAW Solid wires
TYPE	Nickel based filler metal against extreme temperature conditions.
APPLICATIONS	Welding similar alloys 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 build-up capacity and low dilution rate. Excellent resistance against temperature cycling conditions upto 1200^{o}C and carburized medias. Excellent fatique strenght and creep properties.
CLASSIFICATION	AWS A 5.14: ER NiCrFe-12 EN ISO 18274: S Ni 6025 (NiCr25FeAlY) DIN: W.Nr. 2.4649 DIN 1736: SG NiCr25FeAl
SUITABLE FOR	Cladding against high temperature, radiant heater tubes, furnace rolls, muffles in bright annealing furnaces (H_2 atmosphere), rotary kilns, pipe hangers, waste gas components, hydrogen production, methanol and ammonia synthesis, 2.4633, 2.4649, NiCr25FeAlY, Nicrofer 6025 HT, Alloy 602CA, UNS N06025
APPROVALS	CE approved
WELDING POSITIONS:	

FILLER METAL ANALYSIS % (TYPICAL VALUES)

C	Cr	Ni	Mn	Si	Ti	Fe	Al	Y	Zr
0.17	25	61	0.07	0.04	0.14	9,7	2,3	0.07	0.09

MECHANICAL PROPERTIES (TYPICAL)

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V RT	-40°C	-60°C	Hardness HRc / HV
as welded	520	750	26	>60			

WELDING PARAMETERS / PACKING

Welding Parameters		Packing (kg)	
D (mm)	Current (A) DC-	single	master
1.6 x 1000	30-70	5	25
2.0 x 1000	50-80	5	25
2.4 x 1000	70-150	5	25

REDRYING TEMPERATURE	not required
GAS ACC. EN ISO 14175:	I1, R1