

CATEGORY	SMAW Stick Electrodes	
TYPE	Nickel based electrode for NiCrMo welding	
APPLICATIONS	CEWELD® E NiCrMo 686 CPT is designed to weld alloy 686. The weld metal has exceptional resistant to pitting, crevice and general corrosion. It is also suitable to overmatching 625, C276, C4, C22, 59 alloys. Also suitable to weld superduplex and superaustenitic steels.	
PROPERTIES	CEWELD® E NiCrMo 686 CPT electrode has good corrosion resistance in the chemical, process, petrochemical, oil, gas and marine industries. Usable for butt and fillet welds in all positions for diameters 2.4 and 3.2mm. Diameters < 4.0mm excellent in down position.	
CLASSIFICATION	AWS EN ISO F-nr FM W.Nr.	A 5.11: E NiCrMo-14 14172: E Ni 6686 43 6 ~ 2.4606
SUITABLE FOR	Joining Duplex, Superduplex, super austenitic stainless steel, nickel Alloys, N06059, N06022, Hastelloy C276, Alloy C22, Inconel 622, 625, 686, chemical and petrochemical industry, 2.4605, 2.4610, 2.4602, 2.4819, NiCr23Mo16Al, NiMo16Cr15Ti, NiCr21Mo14W, NiMo16Cr15W, alloy 59, alloy C4, alloy 276	
APPROVALS	No Approvals Found	

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	W	Cu
0.01	0.18	0.8	22	55	16	4	3.8	0.35

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A5 (%)
As Welded /	380	740	34

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	PACKING
D (MM)	LENGTH (MM)	CURRENT DC+ (A)	KG / CAN	KG / 6PACK	KG / 1000
2.4	229	40-65	2.27	13.62	
3.2	356	65-95	2.27	13.62	
4.0	356	95-125	2.27	13.62	
4.8	356	125-165	2.27	13.62	

REDRYING TEMPERATURE 300°C / 2 hr

GAS ACCORDING EN 14175