CEWELD® 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 NiCr3T0-4
EN ISO	12153-A: T Ni 6082 (NiCr15Fe6Mn) B M21 3
F-nr	43
FM	6
W.Nr.	2.4648

SUITABLE FOR

E NiCr3 / Ni6082 / NiCr15Fe6Mn
1.5662 - 1.5680 - 1.5637 - 1.4876 - 1.4583 - 2.4816 - 2.4851 - 2.4951 - 2.4806 - 1.4816 - 1.4864 - 1.4886
X8Ni9 - 12Ni19 - 10Ni14 - NiCr15Fe - NiCr23Fe - X10NiCrAlTi3220 - X10CrNiMoNb18.12 - NiCr20Ti
UNS Nr: K81340 - N06600 - N06601 - N08800 - N08810
Alloy 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810

APPROVALS: No Approvals Found

WELDING POSITIONS:

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Nb	Fe	S
0.01	0.3	5	16.5	1.7	6	0.015

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -196°C
As Welded /	390	610	45	90

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING	PACKING	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	140°C / 24 hr
GAS ACCORDING EN 14175	M21