

**CATEGORY** GTAW Solid wires

**TYPE** Nickel based Tig filler metal for welding similar NiCrW alloys.

**APPLICATIONS** In the chemical process industry, CEWELD® Alloy 230 is used for catalyst grid supports in ammonia burners, high-strength thermocouple protection tubes, high-temperature heat exchangers, ducts, high-temperature bellows, and various other key process internals. In the industrial heating industry, applications for 230 alloy include furnace retorts, chains and fixtures, burner flame shrouds, recuperator internals, dampers, nitriding furnace internals, heat-treating baskets, grates, trays, sparger tubes, thermocouple protection tubes, cyclone internals, and many more.

**PROPERTIES** CEWELD® Alloy 230 combines properties which make it ideally suited for a wide variety of component applications in the aerospace and power industries. It is used for combustion cans, transition ducts, flame holders, thermocouple sheaths, and other important gas turbine components.

<b>CLASSIFICATION</b>	AWS	A 5.14: ERNiCrWMo-1
	EN ISO	18274: S Ni 6231(NiCr22W14Mo2)
	F-nr	43
	FM	6
	W.Nr.	2.4733

**SUITABLE FOR** Haynes Alloy 230

**APPROVALS** No Approvals Found

**WELDING POSITIONS:**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	Cr	Ni	Mo	W	Co	Al
0.1	0.4	0.5	22	57	2	14	4	0.3

**ALL WELD MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0.2</sub>	R <sub>m</sub>	A <sub>5</sub>
As Welded /	490	785	48

**WELDING PARAMETERS / PACKING**

D (MM)	WELDING PARAMETERS	WELDING PARAMETERS	VOLTAGE	PACKING (KG)	
				SINGLE	MASTER
1.6	CURRENT (A) DC-		(V)		
	100-140		11-14	4.52	22.6
2.4	120-160		11-14	4.52	22.6

**REDRYING TEMPERATURE** Not required

**GAS ACCORDING EN 14175** I1