CEWELD® Alloy C-2000

CATEGORY	GMAW Solid wires
TYPE	NiCrMo based Mig welding wire for Hastelloy C2000
APPLICATIONS	CEWELD® Alloy C-2000 (UNS N06200) is unique among the versatile nickel-chromium-molybdenum materials in having a deliberate copper addition
PROPERTIES	Like other nickel alloys, it is ductile, easy to form and weld, and possesses exceptional resistance to stress corrosion cracking in chloride-bearing solutions (a form of degradation to which the austenitic stainless steels are prone).It is able to withstand a wide range of oxidizing and non-oxidizing chemicals, and exhibits outstanding resistance to pitting and crevice attack in the presence of chlorides and other halides.

CLASSIFICATION

AWS	A 5.14: ERNiCrMo-17
EN ISO	18274: S Ni 6200(NiCr23Mo16Cu2)
F-nr	43
FM	6
W.Nr.	2.4675

SUITABLE FOR	Alloy C-2000, 2.4675, Ni99,2, Nickel 200
APPROVALS	No Approvals Found

WELDING POSITIONS:

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	Co	Cu
0.01	0.08	0.4	23	60	16	1.5	1	1.6

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT
As Welded /	550	830	45	195

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	PACKING
DIAMETER (MM)	CURRENT TYPE AC/DC	CURRENT (A)	VOLTAGE (V)	KG / SPOOL/TUBE
1,2 MIG	DC+	100-250	19-32	15
1,6 TIG	DC-	25-80	9-12	4.54
2,4 TIG	DC-	75-130	10-13	4,54

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	I1