

CATEGORY SAW Arc Submerged

TYPE Nickel - Chromium alloy for SAW wire.

APPLICATIONS CEWELD® SA Nicro 600 filler metal is used for SAW welding nickel-chromium-iron (Inconel 600, 601 and 690) alloys to themselves, and for dissimilar welding between nickel-chromium-iron (Monel, Inconel and Incoloy) alloys and steels or stainless steels. The applications include surfacing as well as clad-side welding.

PROPERTIES CEWELD® SA Nicro 600 is a solid drawn wire to be used for the submerged arc process in combination with our fused flux CEWELD® FL 880 or agglomerated flux CEWELD® FL 838.

CLASSIFICATION

AWS	A 5.14: ERNiCr-3
EN ISO	18274: S Ni 6082 (NiCr20Mn3Nb)
F-nr	43
FM	6
W.Nr.	2.4806

SUITABLE FOR SA Nicro 600 alloy can be used for: Inconel 600, 2.4816, 1.4876, 2.4817, 2.4851, 1.6901, NiCr15Fe, X10NiCrAlTi 32 20, LC-NiCr15Fe, NiCr23Fe, X3CrNiN 18 10, Alloy 600/B168, Alloy 800/800H(T), N 10665, N 06601, Kiln tyres, cock wheels and difficult to weld steels

APPROVALS No Approvals Found

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Nb	Ti	Fe
0.08	0.3	3	20	70	2.8	0.4	2

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} MPa	R _m MPa	A ₅ (%)	RT	Impact Energy (J) ISO-V -196°C
As Welded /	440	550	33	70	70

WELDING PARAMETERS / PACKING

WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS	WELDING PARAMETERS
D (MM)	VOLTAGE (V)	CURRENT (A)	TRAVEL SPEED (CM/MIN)
1,6	26-29	225-325	35-60
2,4	29-33	300-400	35-60
3,2	29-33	350-500	35-60
4,0	30-36	400-600	35-60

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175