

CEWELD SA Nicro 600

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 EN ISO W.Nr. F-nr FM	A 5.14: ERNiCr-3 18274: S Ni 6082 (NiCr20Mn3Nb) 2.4806 43 6
SUITABLE FOR	E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3, Ni 6082 (NiCr20Mn3Nb) 2.4630, 2.4631, 2.4669, 2.4816, 2.4817, 2.4851, 2.4867, 2.4870, 2.4951 ... (1.4816, 1.4864, 1.4876, 1.4583, 1.4886, 1.5637, 1.5662, 1.5680, 1.6900, 1.6901, 1.6903, 1.6906) NiCr20Ti, NiCr21TiAl, NiCr15Fe7TiAl, NiCr15Fe, LC-NiCr15Fe, NiCr23Fe, NiCr60 15, NiCr80 20, NiCr 10, NiCr20Ti 1.5637 12 Ni 14, X8Ni9, 12Ni19, X12CrNi18 9, GX8CrNi18 10, X10CrNiTi18 10, X5CrNi18 10 UNS Nr: K81340 - N06600 - N06601 - N08800 - N08810 ASTM B163, B166, B167 und B168 Alloy 330, Alloy 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810	

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

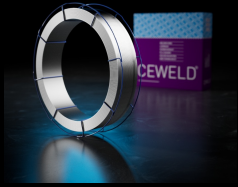
C	Si	Mn	Cr	Ni	Nb	Ti	Fe
0.08	0.3	3	20	70	2.8	0.4	2

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	440	550	33	70	70	HRC

REDRYING Not required

GAS ACC. EN ISO 14175



CEWELD SA Nicro 600

SA Nicro 600 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663418470

SA Nicro 600 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663418487