



# CEWELD AA NiCr 600B

|                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                          |                      |                    |                         |     |          |       |
|----------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------|----------------------|--------------------|-------------------------|-----|----------|-------|
| TYPE                                               | Basic flux-cored nickel base welding wire for gas shielded arc welding.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                          |                      |                    |                         |     |          |       |
| ANWENDUNGEN                                        | 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 !                                                                                                                                                                                                                                                                                                                           |                                          |                      |                    |                         |     |          |       |
| EIGENSCHAFTEN                                      | 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.                                                                                                                                                                                                                                                                            |                                          |                      |                    |                         |     |          |       |
| KLASSIFIKATION                                     | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 12153-A: T Ni 6082 (NiCr15Fe6Mn) R M21 3 |                      |                    |                         |     |          |       |
|                                                    | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 2.4806                                   |                      |                    |                         |     |          |       |
|                                                    | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 43                                       |                      |                    |                         |     |          |       |
|                                                    | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | 6                                        |                      |                    |                         |     |          |       |
| GEEIGNET FÜR                                       | <b>E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3, Ni6082</b><br>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)<br>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<br><b>UNS Nr:</b> K81340 - N06600 - N06601 - N08800 - N08810<br><b>ASTM</b> B163, B166, B167 und B168<br>Alloy 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810 |                                          |                      |                    |                         |     |          |       |
| ZULASSUNGEN                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                          |                      |                    |                         |     |          |       |
| SCHWEISSPOSITIONEN                                 | <div> PA</div> <div> PB</div> <div> PC</div>                                                                                                                                                                                                                                                                                                                                  |                                          |                      |                    |                         |     |          |       |
| TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | Si                                       | Mn                   | Cr                 | Ni                      | Nb  | Fe       | S     |
|                                                    | 0.01                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | 0.3                                      | 5                    | 16.5               | Rem.                    | 1.7 | 6        | 0.015 |
| MECHANISCHE GÜTEWERTE                              | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         | R <sub>p0,2</sub> (MPa)                  | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |     | Hardness |       |
|                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                        |                                          |                      |                    | -196°C                  |     |          |       |
|                                                    | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 390                                      | 610                  | 45                 | 90                      |     | HRc      |       |
| RÜCKTROCKNUNG                                      | 140°C / 24 hr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                          |                      |                    |                         |     |          |       |
| GAS ACC. EN ISO 14175                              | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                          |                      |                    |                         |     |          |       |