



CEWELD E NiCrMo 686 CPT

TYPE Nickel based electrode for NiCrMo welding. (Type ENiCrMo-14, Alloy 686, 2.4606)

APPLICATIONS **CEWELD® E NiCrMo 686 CPT** is designed to weld alloy 686. She is also suitable to overmatching 625, C276, C4, C22, 59 alloys. Also suitable to weld superduplex and superaustenitic steels. Chemical and petrochemical industry, application of corrosion-resistant overlays and valve seat inserts, exhaust gas desulphurization plants

PROPERTIES **CEWELD® E NiCrMo 686 CPT** weld metal is exceptionally resistant to pitting, crevice corrosion and general corrosion. It is suitable for butt and fillet welds in all positions with diameters of 2.4 and 3.2 mm.

CLASSIFICATION

AWS	A 5.11: E NiCrMo-14
EN ISO	14172: E Ni 6686 (NiCr21Mo16W4)
W.Nr.	~ 2.4606
F-nr	43
FM	6

SUITABLE FOR **ENiCrMo-14, E Ni 6686 NiCr21Mo16W4**
2.4602, 2.4605, 2.4606, 2.4607, 2.4610, 2.4819, 2.4656, 1.4529, 1.4547, 1.4565
NiCr23Mo16, NiCr23Mo16Al, NiCr21Mo16W, NiMo16Cr15Ti, NiMo16Cr16Ti, NiCr21Mo14W, NiMo16Cr15W, NiCr22Mo9Nb, Alloy 59, Alloy C4, Alloy 276, X1NiCrMoCuN25-20-7, X1CrNiMoCuN20-18-7
ASTM: C-4, C-276, C-22, 625, 904hMo
UNS: N06059, N06455, N10276, N06625, N08925, S31254, N06686, N06022, N06059, N06200, N08367, N08926, N08031
Duplex, Superduplex, super austenitic stainless steel, Nickel Alloys, N06059, N06022, Hastelloy C276, Alloy C22, Alloy 59. Inconel 622, 625, 686, Outokumpu 654 SMO, Incoloy® Alloy 25-6MO, 27-7MO (Special Metals)

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	W	Cu
0.01	0.18	0.8	22	55	16	4	3.8	0.35

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded	380	740	34	HRc

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E NiCrMo 686 CPT

E NICKRMO 686 CPT 2,4 X
229MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419453

E NICKRMO 686 CPT 3,2 X
356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419460

E NICKRMO 686 CPT 4,0 X
356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419477