



CEWELD E Alloy B3

TYPE Nickel based stick electrode. (Type Alloy B3, Ni1067, E NiMo-10)

APPLICATIONS CEWELD® E Alloy B3 is for welding Hastelloy B2, Hastelloy B3, dissimilar welding Hastelloy to nickel-iron-based corrosion alloys, for weld overlay cladding. It is used in numerous chemical process industry (CPI) applications, especially in the construction of reaction vessels for pure, reducing acid service.

PROPERTIES CEWELD® E Alloy B3 is a nickel-base alloy with excellent resistance to hydrochloric acid at all concentrations and temperatures. It also withstands hydrogen chloride, sulfuric, acetic, hydrofluoric and phosphoric acids. The alloy has improved thermal stability, fabricability and stress corrosion cracking resistance.

CLASSIFICATION

AWS	A 5.11: E NiMo-10
EN ISO	14172: Ni1067 (NiMo30Cr)
W.Nr.	2.4695
F-nr	43

SUITABLE FOR Hastelloy B2, Hastelloy B3 oder B4, Nicrofer® 6629
NiMo29Cr, NiMo28
2.4600, 2.4617
UNS N 10629, N 10629, N10665
ASTM: B 333, B 335, B 564, B 619, B 622, B 626

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	W	Co
0.01	0.1	1.5	2.5	68	27	1.2	1	1

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	400	700	40	120	HRc

REDRYING Not required

GAS ACC. EN ISO 14175



CEWELD E Alloy B3

E ALLOY B3 3,2 X 355MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419897

E ALLOY B3 4,0 X 355MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419927