



CEWELD AA NiCr 600B

TYPE	Basic flux-cored nickel base welding wire for gas shielded arc welding.							
APPLICATIONS	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 !							
PROPERTIES	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.							
CLASSIFICATION	EN ISO	12153-A: T Ni 6082 (NiCr15Fe6Mn) R M21 3						
	W.Nr.	2.4806						
	F-nr	43						
	FM	6						
SUITABLE FOR	E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3, Ni6082 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 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810							
APPROVALS								
WELDING POSITIONS	  							
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Nb	Fe	S
	0.01	0.3	5	16.5	Rem.	1.7	6	0.015
MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	
					-196°C			
	As Welded	390	610	45	90		HRc	
REDRYING	140°C / 24 hr							
GAS ACC. EN ISO 14175	M21							