



CEWELD E Alloy B3

TYPE Nickel based stick electrode

APPLICATIONS Hastelloy B2, Hastelloy B3, dissimilar welding Hastelloy to nickel- of iron-based corrosion alloys, for weld overlay cladding

PROPRIÉTÉS E Alloy B3 is a nickel-base alloy with excellent resistance tot hydrochlorid acid at all concentrations and tempertures. It also withstands hydrogen chloride, sulfuric, acetic, hydrofluoric nd 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

CONVIENT POUR **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

AGRÉMENTS

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL DE
SOUDURE (%)

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

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A5 (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	400	700	40	120	HRc

ETUVAGE 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