



# CEWELD Alloy X Tig

|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                 |                         |                       |                         |    |    |          |    |
|------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------|-------------------------|-----------------------|-------------------------|----|----|----------|----|
| TYPE                                                 | CEWELD Alloy X is a nickel- chromium-iron-molybdenum alloy wire rod                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |                                 |                         |                       |                         |    |    |          |    |
| APPLICATIONS                                         | CEWELD Alloy X Tig is a nickel- chromium-iron-molybdenum alloy that possesses an exceptional combination of oxidation resistance, fabricability and high-temperature strength. It has also been found to be exceptionally resistant to stress-corrosion cracking in petrochemical applications.                                                                                                                                                                                                                                                                                                                 |                                 |                         |                       |                         |    |    |          |    |
| PROPRIÉTÉS                                           | CEWELD Alloy X Tig exhibits good ductility after prolonged exposure at temperatures of 1200, 1400, 1600°F (650, 760 and 870°C) for 16,000 hours. Suitable for joining and cladding Nickel alloys, stainless steel, carbon steel and low alloyed steels. UNS: N06002                                                                                                                                                                                                                                                                                                                                             |                                 |                         |                       |                         |    |    |          |    |
| CLASSIFICATION                                       | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | A 5.14: ERNiCrMo-2              |                         |                       |                         |    |    |          |    |
|                                                      | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 18274: S Ni 6002(NiCr21Fe18Mo9) |                         |                       |                         |    |    |          |    |
|                                                      | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                           | 2.4665                          |                         |                       |                         |    |    |          |    |
|                                                      | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            | 43                              |                         |                       |                         |    |    |          |    |
|                                                      | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              | 6                               |                         |                       |                         |    |    |          |    |
| CONVIENT POUR                                        | 2.4665<br>UNS: N06002<br>Alloy HX, X, AMS 5754, AMS 5798, ASTM B619, Nickel alloys, stainless steel, carbon steel and low alloyed steels.                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                 |                         |                       |                         |    |    |          |    |
| AGRÉMENTS                                            |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                 |                         |                       |                         |    |    |          |    |
| POSITIONS DE SOUDAGE                                 | <div>      </div> |                                 |                         |                       |                         |    |    |          |    |
| ANALYSE CHIMIQUE<br>TYPIQUE DU MÉTAL<br>D'APPORT (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | Si                              | Mn                      | Cr                    | Ni                      | Mo | Fe | W        | Co |
|                                                      | 0.1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 0.8                             | 0.8                     | 22                    | 55                      | 9  | 19 | 0.8      | 2  |
| PROPRIÉTÉS MÉCANIQUES                                | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | R <sub>P0,2</sub><br>(MPa)      | R <sub>m</sub><br>(MPa) | A <sub>5</sub><br>(%) | Impact Energy (J) ISO-V |    |    | Hardness |    |
|                                                      |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 |                                 |                         |                       | RT                      |    |    |          |    |
|                                                      | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                       |                                 | 660                     | 30                    | 100                     |    |    | HRc      |    |
| ETUVAGE                                              | Not required                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                 |                         |                       |                         |    |    |          |    |
| GAS ACC. EN ISO 14175                                | I1                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                              |                                 |                         |                       |                         |    |    |          |    |



# CEWELD Alloy X Tig

ALLOY X TIG 0,8 X 914MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 0,91    | 8720663420299 |

ALLOY X TIG 1,14 X 914MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 4,54    | 8720663420312 |

ALLOY X TIG 1,6 X 914MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 4,54    | 8720663420329 |

ALLOY X TIG 2,4 X 914MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Tube      | 4,54    | 8720663420336 |