

E NiCro 600

CATEGORY SMAW Stick Electrodes

TYPE Nickel based high basic SMAW welding electrode.

APPLICATIONS CEWELD E NiCro 600 electrodes are used for welding of nickel-chromium-iron (Inconel 600, 601 and 690) alloys to themselves, and for dissimilar welding between nickel-chromium-iron (Monel, Inconel and incoloy) alloys and steels or stainless steels. The applications include surfacing as well as clad-side welding. High manganese of this weld deposit reduces the possibility of micro fissures. High manganese reduces creep strength, which limits its usage up to 900°F

PROPERTIES High mechanical properties with excellent thermal shock resistance and impact values at sub zero temperatures down to -196°C

CLASSIFICATION

AWS	A 5.11: E NiCrFe3 F-No. 43
EN ISO	14172: E Ni 6182 FM6
DIN: W.Nr.	2.4807
DIN	1736: EL-NiCr15FeMn

SUITABLE FOR Dissimilar welds for which the electrode are used include INCONEL alloys and INCOLOY or Hastelloy alloys joined to carbon steels, stainless steels, nickel and MONEL alloys, MONEL alloys joined to carbon steels; nickel joined to stainless steels; and stainless steels joined to carbon steels.
Alloy type : Incoloy 800, DS - Inconel 600, 601, UNS Nr (unified numbering system) : K 81340, N06600, N06601, N08800, N08810. DIN design : X8Ni9 - 12Ni19 - 10Ni 14 - NiCr15Fe - NiCr23Fe - X10NiCrAlTi3220 - X10CrNiMoNb18.12 - NiCr20Ti. W.Nrs: 1.5662 - 1.5680 - 1.5637 - 1.4864 - 1.4876 - 1.4583 - 2.4816 - 2.4851 - 2.4951, 2.4806, Alloy 82, 1.4816, 600L, 800H, Alloy 80A, Alloy 75, difficult to Weld steel, chain, cock wheels, kiln tyre

APPROVALS CE approved

WELDING POSITIONS:



WELT METAL ANALYSIS %

Ni	C	Mn	Fe	S	Si	Cu	Ti	Cr	Nb	P	Other
> 59.0	< 0.10	5.0-9.5	< 10.0	0.015	< 1.0	< 0.50	< 1.0	13.0-17.0	1.0-2.5	< 0.030	< 0.50

MECHANICAL PROPERTIES

Heat Treatment	Tensile strength		Yield strength		Elongation (%)
	(PSI)	(MPA)	(PSI)	(MPA)	
AW	>80,000	>552	>53.5	>370	36

AW: as welded

WELDING PARAMETERS PACKING

Welding Parameters			Packing	
D (mm)	Length (mm)	Current (A) DC+	kg / can	kg / 6pack
2.4	229	40-65	2.27	13.62
3.2	356	65-95	2.27	13.62
4.0	356	95-125	2.27	13.62