CEWELD®

AA NiCro 600B

CATEGORY	FCAW Flux-Cored
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	AWS A 5.34: E NiCr3 T 0-4 EN ISO 12153 T Ni 6082 R M21 3 DIN: W.Nr. 2.4648
SUITABLE FOR	Alloy type : Incoloy 800, DS - Inconel 600, 601, UNS Nr (unified numbering system) : K 81340, N06600, N 06601, N 08800, N 08810. DIN design : X8Ni9 - 12Ni19 - 10Ni 14 - NiCr15Fe - NiCr23Fe - X10NiCrAlTi3220 - X10CrNiMoNb18.12 - NiCr20Ti. Mat n° : 1.5662 - 1.5680 - 1.5637 - 1.4876 - 1.4583 - 2.4816 - 2.4851 - 2.4951, 2.4806, Alloy 82, 1.4816, 600L, 800H, difficult to Weld steel, chain, cock wheels, kiln tyre
APPROVALS	CE approved
WELDING POSITIONS:	

ALL-WELD METAL ANALYSES %

C	Mn	Si	Cr	Ni	Nb	Fe
0.01	6.0	0.3	17.0	bal	1.7	6.0

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-196°C	Hardness HRc / HV
AW	380	610	45			90	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	Spools	kg/spool	kg/pallet
1.2	24-32	130-250	K-300	15	1080
1.6	24-32	150-300	K-300	15	1080

REDRYING TEMPERATURE	150ºC / 24hr
GAS ACC.EN ISO 14175:	M21