

Nicro 600

CATEGORY	GMAW-GTAW Solid wires											
TYPE	Solid nickel base welding wire for GMAW welding.											
APPLICATIONS	Nicro 600 filler metal is used for welding 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.											
PROPERTIES	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.											
CLASSIFICATION	AWS	A 5.14: ER NiCr-3										
	EN ISO	18274: S Ni 6082 (NiCr20Mn3Nb)										
	DIN: W.Nr.	2.4806										
	DIN	1736: SG NiCr20Nb										
SUITABLE FOR	inconel 600, 2.4816, 1.4876, 2.4817, 2.4851, 1.6901, NiCr15Fe, X10NiCrAlTi 32 20, LC-NiCr15Fe, NiCr23Fe, X3CrNiN 18 10, alloy 600/B168, alloy 800 / 800H(T), N 10665, N 06601, kiln tyre, difficult to Weld steels, cock wheels											
APPROVALS	CE approved											
WELDING POSITIONS:												
WELD METAL ANALYSIS %	C	Mn	Si	Cr	S	Nb+Ta	Ti	Fe	Co	Cu	P	Ni
	< 0.10	2.5-3.5	< 0.5	18-22	< 0.015	2.0-3.0	< 0.75	< 3.0	< 0.12	< 0.5	< 0.03	> 67
MECHANICAL PROPERTIES												
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V								
AW	> 420	> 640	> 35	+20°C				-196°C				
				> 200				> 100				
AW: as welded												
WELDING PARAMETERS / PACKING												
Welding Parameters						Packing (kg)						
D (mm)	Voltage (V)		Current (A) (DC+)			Spool type		kg / spool				
0,8	16-26		80-180			S-300		15				
1,0	16-29		100-250			S-300		15				
1,2	18-29		125-290			S-300		15				
REDRYING TEMPERATURE	not required											
GAS ACC. EN ISO 14175:	I1, I3 (Ar-He)											