

NiCro 602 CA (6025HT)

CATEGORY GMAW-GTAW Solid wires

TYPE Nickel based filler metal against extreme temperature conditions.

APPLICATIONS Welding similar alloys that have to resist extreme high temperature and for cladding steels or stainless steels to obtain a high temperature resistant surface against oxidation.

PROPERTIES Excellent welding properties with high build-up capacity and low dilution rate. Excellent resistance against temperature cycling conditions upto 1200°C and carburized medias. Excellent fatigue strenght and creep properties.

CLASSIFICATION

AWS	A 5.14: ER NiCrFe-12
EN ISO	18274: S Ni 6025 (NiCr25FeAlY)
DIN: W.Nr.	2.4649
DIN	1736: SG NiCr25FeAl

SUITABLE FOR Cladding against high temperature, radiant heater tubes, furnace rolls, muffles in bright annealing furnaces (H₂ atmosphere), rotary kilns, pipe hangers, waste gas components, hydrogen production, methanol and ammonia synthesis, 2.4633, 2.4649, NiCr25FeAlY, Nicrofer 6025 HT, Alloy 602CA, UNS N06025

APPROVALS CE approved

WELDING POSITIONS:



FILLER METAL ANALYSIS %

C	Cr	Ni	Mn	Si	Ti	Fe	Al	Co	Zr	S	Cu	P	Other (total)
0.15-0.25	24.0-26.0	Rem	0.50	0.50	0.10-0.20	8.0-11.0	1.80-2.40	1.0	0.01-0.10	0.010	0.10	0.020	0.50

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				RT	-40°C	-60°C	
as welded	520	750	26	>60			

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1,2	28-32	180-220	S-300	15	1080

REDRYING TEMPERATURE not required

GAS ACC. EN ISO 14175: I1, Argon+Helium (70-30)