

SA Nicro 600 strip

CATEGORY ESWA Electroslag

TYPE Nickel Chromium based strip for cladding applications

APPLICATIONS This strip is suitable for both electroslag (ESW) and subarc (SAW) process. Typical applications include cladding of vessels for the petrochemical, refinery and chemical industries

PROPERTIES Weld metal deposited by SA Nicro 600 has high strength and good corrosion resistance, including oxidation resistance and creep-rupture strength at elevated temperatures.

CLASSIFICATION

| | |
|------------|----------------------------------|
| AWS | AWS A5.14 ERNICKR-3 (UNS N06082) |
| | AWS A5.14 EQNICKR-3 |
| EN ISO | 18274 - S Ni6082 (NICR20MN3NB) |
| DIN: W.Nr. | 2.4806 |

SUITABLE FOR SA Nicro 600 is mainly used for ESW and SAW cladding of carbon steel to obtain corrosion and creep resistant layers. Go to [FL 860 ESHC](#) suitable flux...

WELDING POSITIONS:



CHEMICAL ANALYSIS (%)

| Cr | Ni | C | Mn | Si | Fe | Cu | Ti | Nb |
|-------|-----|------|---------|-------|------|-------|-------|---------|
| 18-22 | >67 | <0,1 | 2,5-3,5 | <0,50 | <3,0 | <0,50 | <0,75 | 2,0-3,0 |

MECHANICAL PROPERTIES (TYPICAL)

| Heat Treatment | R _{p0,2} (N/mm ²) | R _m (N/mm ²) | A ₅ (%) | Impact Energy (J) ISO-V | | | Hardness HRc / HV |
|----------------|--|-------------------------------------|--------------------|-------------------------|-------|-------|-------------------|
| | | | | -20°C | -40°C | -60°C | |
| AW | 390 | 650 | 37 | | | | |

WELDING PARAMETERS WITH FL 860 ESHC / PACKING

| thickness (mm) | Welding Parameters | | Packing | |
|----------------|--------------------|-------------------|--------------|-----------|
| | width (mm) | Current (A) (DC+) | Coil ID (mm) | kg / Coil |
| 0,5 | 30 | 450-650 | 600 | 25-50 |
| 0,5 | 60 | 1050-1250 | 600 | 50-100 |
| 0,5 | 90 | 1475-1800 | 600 | 100-200 |
| 0,5 | 120 | 1800-2400 | 600 | 200-300 |

REDRYING TEMPERATURE NA