



# CEWELD SA Nicro 600 strip

**TYPE** Nickel Chromium solid strip

**APPLICATIONS** This strip is suitable for both electroslag (ESW) and sub arc (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. Use FL 860 ESHC flux

**CLASSIFICATION**

AWS	A 5.14: EQNiCr-3
EN ISO	18274: B Ni 6082 (NiCr20Mn3Nb)
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

**E Ni 6182 (Ni Cr 15 Fe6Mn), E NiCrFe-3**  
 2.4630, 2.4631, 2.4669, 2.4816, 2.4817, 2.4851, 2.4867, 2.4870, 2.4951 ... (1.4816, 1.4864, 1.4876, 1.4583, 1.4886, 1.5637, 1.5662, 1.5680, 1.6900, 1.6901, 1.6903, 1.6906)  
 NiCr20Ti, NiCr21TiAl, NiCr15Fe7TiAl, NiCr15Fe, LC-NiCr15Fe, NiCr23Fe, NiCr60 15, NiCr80 20, NiCr 10, NiCr20Ti 1.5637 12 Ni 14, X8Ni9, 12Ni19, X12CrNi18 9, GX8CrNi18 10, X10CrNiTi18 10, X5CrNi18 10

**UNS Nr:** K81340 - N06600 - N06601 - N08800 - N08810  
**ASTM** B163, B166, B167 und B168  
 Alloy 600, Alloy 600 L, Alloy 800 / 800H UNS N06600, N07080, N0800, N0810

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)**

C	Si	Mn	P	S	Cr	Ni	Nb	Ti	Fe
0.08	0.4	3	0.02	0.01	21	75	2.8	0.2	2

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Hardness
As Welded	390	650	37	HRc

**REDRYING** Not required

**GAS ACC.** EN ISO 14175