



CEWELD E NiCr 690

TYPE Nickel based high basic SMAW welding electrode. (Type Alloy 690)

APPLICATIONS CEWELD E NiCr 690 electrodes are used for welding of nickel-chromium-iron Inconel alloys 690 to themselves and 600 steels. Also for heterogeneous stainless and low-alloy steels. Soft arc, easily detachable slag, regular beads. Nuclear power plants, chemical industry.

PROPRIÉTÉS CEWELD E NiCr 690 has a higher Cr content which improves resistance to stress-corrosion cracking in the nuclear, pure water environment.

CLASSIFICATION

| | |
|--------|----------------------------|
| AWS | A 5.11: ENiCrFe-7 |
| EN ISO | 14172: Ni 6152 NiCr30Fe9Nb |
| F-nr | 43 |
| FM | 6 |

CONVIENT POUR **Alloy 690, UNS W86152, NiCrFe-7**
Inconel 690, VDM Alloy 690, Nicrofer 6030 N, FM 52, 2.4642, NiCr29Fe, Inconel 600, NiCr30Fe9Nb

AGRÉMENTS

POSITIONS DE SOUDAGE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | Cr | Ni | Mo | Nb | Fe |
|------|-----|----|----|------|-----|-----|----|
| 0.04 | 0.5 | 4 | 29 | Rem. | 0.3 | 1.5 | 7 |

PROPRIÉTÉS MÉCANIQUES

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--|----------|
| | | | | RT | | |
| As Welded | 430 | 650 | 40 | 110 | | HRC |

ETUVAGE Not required

GAS ACC. EN ISO 14175