




# CEWELD SA Nicro 602 CA (6025HT) strip

TYPE	Nickel based solid strip																				
TOEPASSINGEN	Electro slag cladding jobs that have to resist extreme high temperature and for cladding steels or stainless steels to obtain a high temperature resistant surface against oxidation.																				
EIGENSCHAPPEN	Excellent welding properties with high buildup capacity and low dilution rate when combined with FL 860 ESHC. Excellent resistance against temperature cycling conditions up to 1200°C and carburized medias. Excellent fatigue strength and creep properties.																				
CLASSIFICATIE	AWS                    A 5.14: EQNiCrFe-12 EN ISO                18274: B Ni 6025 (NiCr25Fe10AlY) W.Nr.                 2.4649																				
GESCHIKT VOOR	Cladding against high temperature, radiant heater tubes, furnace rolls, muffles in bright annealing furnaces (H2 atmosphere), rotary kilns, waste gas components, hydrogen production, methanol and ammonia synthesis, 2.4633, NiCr25FeAlY, Nicrofer 6025 HT.																				
GOEDKEURINGEN																					
LASPOSITIES																					
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table><thead><tr><th>C</th><th>Si</th><th>Mn</th><th>P</th><th>S</th><th>Cr</th><th>Ni</th><th>Ti</th><th>Fe</th><th>Al</th></tr></thead><tbody><tr><td>0.18</td><td>0.04</td><td>0.08</td><td>0.01</td><td>0.09</td><td>25</td><td>63</td><td>0.13</td><td>9.5</td><td>2.3</td></tr></tbody></table>	C	Si	Mn	P	S	Cr	Ni	Ti	Fe	Al	0.18	0.04	0.08	0.01	0.09	25	63	0.13	9.5	2.3
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MECHANISCHE WAARDEN																					
HERDROGEN	Not required																				
GAS ACC. EN ISO 14175																					