



CEWELD E NiCrO A

TYPE Nickel based high basic SMAW welding electrode. (Type E NiCrFe-2, E Ni 6092)

APPLICATIONS **CEWELD® E NiCrO A** electrodes are used for welding Incoloy alloys 800 and 800HT, Inconel 600 and 601 and nickel alloys. Examples include combinations of stainless steels, carbon steels, INCONEL alloys, INCOLOY alloys, MONEL alloys and copper-nickel alloys. Due to its versatility, it is particularly useful for general maintenance welding on equipment exposed to harsh operating conditions.

PROPERTIES The weld metal of **CEWELD® E NiCrO A** has excellent strength and oxidation resistance at high temperatures and retains its impact strength at low temperatures. The electrode is exceptionally versatile for dissimilar joint welding. It can be used on a wide range of austenitic and ferritic steels and nickel alloys.

CLASSIFICATION	AWS	A 5.11: E NiCrFe-2
	EN ISO	14172: E Ni 6092 (NiCr16Fe9NbMo)
	W.Nr.	2.4805
	F-nr	43
	FM	6

SUITABLE FOR **E Ni 6092 (NiCr16Fe12NbMo), ENiCrFe-2**
Mat No: 2.4630, 2.4631, 2.4669, 2.4694, 2.4816, 2.4817, 2.4851, 2.4867, 2.4869, 2.4870, 2.4951, 2.4952.. (1.4859, 1.4861, 1.4876, 1.4877, 1.4885, 1.4958, 1.4968, 1.5637, 1.5662, 1.5680, 16900, 1.6903, 1.6906)
NiCr15Fe, X10NiCrAlTi 32 20, G-X10NiCrNiNb 32 20, NiCr20Ti, NiCr20TiAl, X8Ni9, X7NiMo6, 12Ni19, 12Ni14
ASTM: Alloy 600, Alloy 800, Alloy 800H, Alloy 75, Alloy 80A, B163, B166, B167, B168

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	Nb+Ta	Nb
0.08	0.6	2.8	15	70	2	9.5	2.8	2

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	420	600	40	100	80	HRC

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E NiCro A

E Nicro A 2,4 X 229MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418500

E Nicro A 3,2 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418517

E Nicro A 4,0 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418524

E Nicro A 4,8 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418531