



# CEWELD Alloy B3 Tig

**TYPE** Nickel based wire or rod for welding Hastelloy B2 and B3

**APPLICATIONS** Plants for the production and processing of hydrochloric, sulfuric, acetic and phosphoric acids. Plants for ethylbenzene production. Pressure vessels for chloroprene production. Plants for the production of phenol from isopropyl benzene. Pyrolysis plants for the production of acetic anhydride

**PROPERTIES** CEWELD® Alloy B3 Tig is a nickel-base alloy with excellent resistance tot hydrochlorid acid at all concentrations and tempertures. It also withstands hydrogen chloride, sulfuric, acetic, hydrofluoric nd phosphoric acids. The alloy has improved thermal stability, fabricability and stress corrosion cracking resistance.

**CLASSIFICATION**

AWS	A 5.14: ERNiMo-10
EN ISO	18274: S Ni 1067(NiMo30Cr)
W.Nr.	2.4600
F-nr	43
FM	6

**SUITABLE FOR** **Hastelloy B2, Hastelloy B3,**  
17744, 17750, 17751, 17752, 17753  
ASTM: B 333, B 335, B 564, B 619, B 622, B 626

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

C	Si	Mn	Cr	Ni	Mo	Ti	V	Fe	W	Co
0.001	0.08	0.59	1.54	67.2	28.6	0.05	0.008	1.44	0.5	0.3

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	540	820	45	195		HRc

**REDRYING** Not required

**GAS ACC. EN ISO 14175** 11