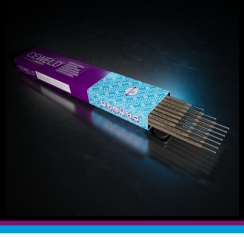


CEWELD E NiCrMo 686 CPT

certilas® THE FILLER METAL SPECIALIST

TYPE

Electrode enrobée base nickel NiCrMo welding

APPLICATIONS

CEWELD® E NiCrMo 686 CPT electrode for welding duplex, super-duplex and super-austenitic stainless steels as well as nickel alloys such as UNS N06059 and N06022, Inconel alloy C-276 and Inconel alloys 622, 625 and 686.

PROPRIÉTÉS

CEWELD® E NiCrMo 686 CPT electrode has good corrosion resistance in pollution controlled engineering and in chemical, process, petrochemical, oil and gas, and marine industries. Useable for butt- and fillet welding in all positions for diameters 2,4 and 3,2mm. Diameters >4,0 excellent in downhand position.

CLASSIFICATION

AWS	A 5.11: E NiCrMo-14
EN ISO	14172: E Ni 6686 (NiCr21Mo16W4)
W.Nr.	~ 2.4606
F-nr	43
FM	6

CONVIENT POUR

ENiCrMo-14, E Ni 6686 NiCr21Mo16W4
2.4602, 2.4605, 2.4607, 2.4610, 2.4819, 2.4656, 1.4529,1.4547, 1.4565
NiCr23Mo16, NICr23Mo16Al, NiMo16Cr15Ti, NiMo16Cr16Ti, NiCr21Mo14W, NiMo16Cr15W, NiCr22Mo9Nb, Alloy 59, Alloy C4, Alloy 276, X1NiCrMoCuN25-20-7, X1CrNiMoCuN20-18-7
ASTM: C-4, C-276, C-22, 625, 904hMo
UNS: N06059, N06455, N10276, N06022, N06625, N08925, S31254
Duplex, Superduplex, super austenitic stainless steel, Nickel Alloys, N06059, N06022, Hastelloy C276, Alloy C22, Inconel 622, 625, 686, Outokumpu 654 SMO,

AGRÉMENTS

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	W	Cu
0.01	0.18	0.8	22	55	16	4	3.8	0.35

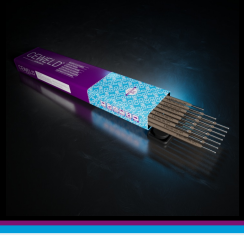
PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Hardness
As Welded	380	740	34	HRc

ETUVAGE

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E NiCrMo 686 CPT

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E NICRMO 686 CPT 2,4 X 229MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419453

E NICRMO 686 CPT 3,2 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419460

E NICRMO 686 CPT 4,0 X 356MM

Packaging	KG/unit	EanCode
Can	2,27	8720663419477