



# CEWELD E NiCrMo 686 CPT

|                                             |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                 |     |                         |                      |    |                    |          |      |
|---------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------|-----|-------------------------|----------------------|----|--------------------|----------|------|
| TYPE                                        | Nickel based electrode for NiCrMo welding. (Type ENiCrMo-14, Alloy 686, 2.4606)                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                 |     |                         |                      |    |                    |          |      |
| APPLICATIONS                                | <b>CEWELD® E NiCrMo 686 CPT</b> is designed to weld alloy 686. She is also suitable to overmatching 625, C276, C4, C22, 59 alloys. Also suitable to weld superduplex and superaustenitic steels. Chemical and petrochemical industry, application of corrosion-resistant overlays and valve seat inserts, exhaust gas desulphurization plants                                                                                                                                                                                                                                                                                                                                                           |                                 |     |                         |                      |    |                    |          |      |
| PROPERTIES                                  | <b>CEWELD® E NiCrMo 686 CPT</b> weld metal is exceptionally resistant to pitting, crevice corrosion and general corrosion. It is suitable for butt and fillet welds in all positions with diameters of 2.4 and 3.2 mm.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  |                                 |     |                         |                      |    |                    |          |      |
| CLASSIFICATION                              | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | A 5.11: E NiCrMo-14             |     |                         |                      |    |                    |          |      |
|                                             | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | 14172: E Ni 6686 (NiCr21Mo16W4) |     |                         |                      |    |                    |          |      |
|                                             | W.Nr.                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                   | ~ 2.4606                        |     |                         |                      |    |                    |          |      |
|                                             | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    | 43                              |     |                         |                      |    |                    |          |      |
|                                             | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      | 6                               |     |                         |                      |    |                    |          |      |
| SUITABLE FOR                                | <b>ENiCrMo-14, E Ni 6686 NiCr21Mo16W4</b><br>2.4602, 2.4605, 2.4606, 2.4607, 2.4610, 2.4819, 2.4656, 1.4529,1.4547, 1.4565<br>NiCr23Mo16, NiCr23Mo16Al, NiCr21Mo16W, NiMo16Cr15Ti, NiMo16Cr16Ti, NiCr21Mo14W, NiMo16Cr15W, NiCr22Mo9Nb, Alloy 59, Alloy C4, Alloy 276, X1NiCrMoCuN25-20-7, X1CrNiMoCuN20-18-7<br><b>ASTM:</b> C-4, C-276, C-22, 625, 904hMo<br><b>UNS:</b> N06059, N06455, N10276, N06625, N08925, S31254,N06686, N06022, N06059, N06200, N08367, N08926, N08031<br>Duplex, Superduplex, super austenitic stainless steel, Nickel Alloys, N06059, N06022, Hastelloy C276, Alloy C22, Alloy 59. Inconel 622, 625, 686, Outokumpu 654 SMO, Incoloy® Alloy 25-6MO, 27-7MO (Special Metals) |                                 |     |                         |                      |    |                    |          |      |
| APPROVALS                                   |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                 |     |                         |                      |    |                    |          |      |
| WELDING POSITIONS                           | <div>    </div>                                                                                                                                                                                                                                                          |                                 |     |                         |                      |    |                    |          |      |
| 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 |
| MECHANICAL PROPERTIES                       | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          |                                 |     | R <sub>P0,2</sub> (MPa) | R <sub>m</sub> (MPa) |    | A <sub>5</sub> (%) | Hardness |      |
|                                             | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               |                                 |     | 380                     | 740                  |    | 34                 | HRc      |      |
| REDRYING                                    | 300°C / 2 hr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                 |     |                         |                      |    |                    |          |      |
| GAS ACC. EN ISO 14175                       |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |                                 |     |                         |                      |    |                    |          |      |



# CEWELD E NiCrMo 686 CPT

E NICKRMO 686 CPT 2,4 X  
229MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,27    | 8720663419453 |

E NICKRMO 686 CPT 3,2 X  
356MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,27    | 8720663419460 |

E NICKRMO 686 CPT 4,0 X  
356MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,27    | 8720663419477 |