

ASME II C SFA 5.14 :	EQ NiCr3
EN ISO 18274 :	B Ni 6082
DIN 1736 :	UP Ni Cr 20 Nb
W-Nr :	2.4806

DESCRIPTION

- Soudotape NiCr3 is mainly designed for cladding of alloy 600 (UNS N06600) on un or low alloyed steels using Sub-arc (SAW) or Electroslag (ESW) welding processes.
- The chemical composition of Alloy 600 is achievable in min two layers using Record NFT 201 in SAW and Record EST 201 or Record EST 236 in ESW.

SUITABLE FOR

- Components for power and heat generation in power production plants.

STRIP ANALYSIS

Strip designation	C	Mn	Si	Cr	Ni	Nb
SOUDOTAPE NiCr3	0.015	3.2	0.2	20.6	Balance	2.7

TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Submerged arc strip cladding with RECORD NFT 201

	Flux RECORD	C	Mn	Si	Cr	Ni	Nb	Fe	Thickn. (mm)
2 nd Layer (Alloy 600)	NFT 201	0.02	3.6	0.3	19.8	Bal.	2.2	3.0	4.2

- Electroslag strip cladding with RECORD EST 201 / Record EST 236

	Flux RECORD	C	Mn	Si	Cr	Ni	Nb	Fe	Thickn. (mm)
2 nd Layer (Alloy 600)	EST 201	0.02	2.8	0.3	19.4	Bal.	2.5	3.8	3.6
2 nd Layer (Alloy 600)	EST 236	0.025	2.8	0.4	19.8	Bal.	2.4	5.0	3.0
2 nd Layer (Alloy 600)	EST 229	0.032	2.8	0.1	21.1	Bal.	2.4	4.3	3.6

APPROVALS

RECORD	TÜV
NiCrT	09407.00
EST 201	08072.03 (KTA 1408.1)
EST 201	04617.03

AVAILABLE STRIP SIZES

- Standard: 60 x 0.5 mm or 30 x 0.5 mm.
- Other sizes on request.

PACKING

- 60 x 0.5 mm : 50 kg to 60 kg.
- 30 x 0.5 mm : 25 kg to 30 kg.
- Other sizes on request.

Note : For additional information about cladding conditions and deposited weld metal properties, please refer to the corresponding flux technical data sheet, cladding data sheet or contact us.