



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										
PROPRIÉTÉS	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	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiMo-10</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 1067(NiMo30Cr)</td> </tr> <tr> <td>W.Nr.</td> <td>2.4695</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.14: ERNiMo-10	EN ISO	18274: S Ni 1067(NiMo30Cr)	W.Nr.	2.4695	F-nr	43	FM	6
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CONVIENT POUR	Hastelloy B2, Hastelloy B3 oder B4, Nicrofer® 6629 NiMo29Cr, NiMo28 2.4600, 2.4617 UNS N 10629, N 10629, N10665 ASTM: B 333, B 335, B 564, B 619, B 622, B 626										

AGRÉMENTS

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE
TYPIQUE DU MÉTAL DE
SOUDURE (%)

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

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness
				RT		
As Welded	540	820	45	195		HRc

ETUVAGE Not required

GAS ACC. EN ISO 14175 I1