

CWR-606 Welding Wire and Rod

CWR-606 is a nickel-chromium-iron filler metal used to weld nickel base alloys such as 600, 601, 690 and 800. It is also used for welding dissimilar metals and for overlaying on steel.

CONFORMANCES

AWS A5.14	:	ERNiCr-3
ASME SFA-5.14	:	ERNiCr-3
UNS	:	N06082

AWS CHEMICAL COMPOSITION (TYPICAL)

%C	%Cr	%Ni	%Nb (Cb)	%Ti	%Fe	%Mn
0.10 max	18.0 – 22.0	67.0 min	2.0 – 3.0	0.75 max	3.0 max	2.5 – 3.5
%Si	%P	%S	%Cu	%Co	Total Others	
0.50 max	0.03 max	0.015 max	0.50 max	0.12 max	0.50 max	

TYPICAL WELD METAL MECHANICAL PROPERTIES

Yield Strength	:	50,000 psi
Tensile Strength	:	85,000 psi
Elongation	:	35 %

TYPICAL WELDING PARAMETERS*

Process	Diameter		Voltage	Amperage	Gas/Flux
TIG (GTAW)	1/16"	1.6 mm	14 – 18	90 – 130	100% Ar
	3/32"	2.4 mm	15 – 20	120 – 170	100% Ar
	1/8"	3.2 mm	15 – 20	150 – 220	100% Ar
MIG (GMAW)	.035"	0.9 mm	26 – 29	150 – 200	75% Ar – 25% He
	.045"	1.1 mm	28 – 32	180 – 220	75% Ar – 25% He
Sub Arc (SAW)	.093"	2.4 mm	28 – 30	275 – 350	
	.125"	3.2 mm	29 – 32	350 – 450	

*All parameters are suggested as basic guidelines only and will vary depending on joint design, number of passes and other factors.

<p>IMPORTANT: SPECIAL VENTILATION AND/OR EXHAUST REQUIRED</p> <p>BEFORE USE, READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) FOR THIS PRODUCT AND SPECIFIC INFORMATION PRINTED ON THE PRODUCT CONTAINER.</p>

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