

Classifications

ASME II C SFA 5.14	EN ISO 18274
EQNiCr-3	B Ni 6082 (NiCr20Mn3Nb)

Characteristics and typical fields of application

SOUDOTAPE NiCr3 is a nickel chromium alloy strip electrode.

Developped to met extra low iron content weldoverlay.

With Submerged Arc Strip Cladding flux RECORD NFT 201, NiCr20Nb (2.4806 ; N06082 ; NiCr-3) deposit weldoverlay is met from second layer.

With ElectroSlag strip Cladding flux RECORD EST 201, NiCr20Nb (2.4806 ; N06082 ; NiCr-3) deposit weldoverlay is met from second layer with final overthickness under 7mm

With ElectroSlag strip Cladding flux RECORD EST 236,

NiCr20Nb (2.4806 ; N06082 ; NiCr-3) deposit weldoverlay is met from second layer even at high speed

Cladding with SOUDOTAPE NiCr3 is resistant to a wide range of corrosive media with good oxidation resistance at high temperature.

Suitable solution useful in various applications across several industries. Components for chemical process industry, power and heat generation in power production plants.

Best resistance to corrosion in high purity water.

SOUDOTAPE NiCr3 is qualified by the nuclear industry in combination with RECORD NiCr3T Q5

SOUDOTAPE NiCr3 is also suitable for buffer layer before Nickel-base weld-overlays.

Typical analysis

	C	Si	Mn	Cr	Ni	Nb	Ti	Fe
wt.-%	0.01	0.1	3.1	20.1	Rem.	2.7	0.3	0.3

Typical fluxes to combine

Process	Name	EN ISO 14174
ESW	RECORD EST 201	ES A FB 2B
ESW	RECORD EST 236	ES A FB 2B
SAW	RECORD NFT 201	S A AB 2B
SAW	RECORD NiCr3T Q5	S A AB 2B

Packaging

Size(s) in mm	Type	Weight
30 x 0,5	Coil	25 - 30 kg
60 x 0,5	Coil	50 - 60 kg
90 x 0,5	Coil	75 - 90 kg

Other sizes and coil weights on request.