

**Coating type:**

Basic

**Current:**



**Welding positions:**



**Arc voltage:** 60V

**Tip colour:**

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**Printing:**

Hilchrome 600/E NiCrFe3

Hilchrome 600 is our basic coated DC electrode for welding high-grade nickel-base alloys like Inconel® 600. Typical applications include joining and surfacing high-temperature and creep resisting steels, heat resisting and cryogenic materials i.e. cold-tough steels (9% Ni), dissimilar joining and low-alloyed problem steels. Electrode is suitable for usage between -196°C up to +650°C, maximum operating temperature of 1200°C (in a S-free environment), highly resistant to hot cracking. Hilchrome 600 is core wire alloyed.

**Base materials to be welded:**

- ASTM/AISI Grade Alloy 600/B168, Alloy 75, Alloy 80A
- Inconel® 600, 601, 690 - Incoloy® 800
- WNr. 2.4816, 2.4951, 2.4952
- NiCr15Fe and nickel alloys of similar composition
- Ni-steel up to and including 9% Ni
- Dissimilar joining

**Applications:**

- Power Generation
- Repair & Maintenance
- Oil & Gas Industry
- Process Industry

**Equivalent product in alternative welding process:**

SMAW	GMAW	FCAW	GTAW	SAW	Gas welding / brazing
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**Chemical composition, wt. % weld metal – typical:**

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Nb	Fe	Al
0,04	6,0	0,40	≤ 0,030	≤ 0,030	16,0	Bal.			2,0	6,0	

**Mechanical properties, weld metal – typical:**

Condition	0,2% Yield strength MPa	Tensile strength MPa	Elongation Lo=5d - %	Impact Values ISO-V J
As welded	≥ 380	≥ 620	≥ 35	+20°C ≥ 80 -196°C ≥ 65

**Packaging and welding data:**

Dia. mm.	Length mm.	Weight (kgs) 1000 pcs.	Current A
2,5	300	17,7	50- 70
3,2	350	27,4	70-95
4,0	350	50,0	90-120