# HILCO HILCHROME 600

Stick electrodes – stainless steel – nickel base

AWS A5.11: E NiCrFe3

EN ISO 14172 : E Ni 6182 (NiCr15Fe6Mn)

Werkstoffnr. 2.4807

**Coating type:**
Basic

**Current:**
=+

**Welding positions:**

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 -196ºC up to +650ºC, maximum operating temperature of 1200º (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

**Chemical composition, wt. % weld metal – typical:**

| C | Mn | Si | Cr | Ni | Nb | Fe |
|---|---|---|---|---|---|---|
| 0,025 | 6,0 | 0,40 | 16,0 | Bal. | 2,2 | 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 | ≥ 360 | ≥ 600 | ≥ 30 | 20ºC ≥ 90<br>-196°C ≥ 32 |

**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 |



Kilkenny Welding Supplies LTD.
Cuffesgrange, Co.Kilkenny PH: (056) 7729949
Portlaoise, Co.Laois PH: (057) 8621479
info@kws.ie www.kws.ie