CEWELD Alloy 825 Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid Nickel based welding wire for gas tungsten arc welding

APPLICATIONS

The excellent corrosion-resistant properties of CEWELD Alloy 825 make the alloy a suitable choice for a variety of difficult applications. Uses include fabricated equipment found in chemical and petro- chemical processing, pulp and paper manufacturing, flue gas desulphurization systems and metal pickling operations.

PROPERTIES

Excelent weldabillity with fully austenitic weld metal with high resistance against stress corrosion cracking and pitting in media containing chloride ions. Good corrosion resistance against reducing acids due to the combination of Ni, Mo and Cu. Sufficient resistance against oxidizing acids. The weld metal is corrosion resistant in sea water. Good resistance to nitric acid.

CLASSIFICATION

AWS	A 5.14: ERNiFeCr-1
EN ISO	18274: S Ni 8065(NiFe30Cr21Mo3)
F-nr	43
FM	6
W.Nr.	2.4858

SUITABLE FOR

G-X7NiCrMoCuNb25-20, X1NiCrMoCuN25-20-6, X1NiCrMoCuN25-20-5, NiCr21Mo, X1NiCrMoCu31-27-4,
N08926, N08904, N08028, N08825 ALLOY 825
1.4500, 1.4529, 1.4539 (904L), 2.4858, 1.4563, 1.4465, 1.4577 (310Mo), 1.4133, 1.4500, 1.4503, 1.4505, 1.4506, 1.4531, 1.4536, 1.4585, 1.4586

APPROVALS

No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Cu
0.04	4	0.8	21	42	2	1	30	2

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT
As Welded /	425	630	30	100

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

I1

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	Type	KG/unit	EANCode
ALLOY 825 TIG 1,2 X 1000MM	Tube	5	8720663419613
ALLOY 825 TIG 1,6 X 1000MM	Tube	5	8720663419644
ALLOY 825 TIG 2,0 X 1000MM	Tube	5	8720663419637
ALLOY 825 TIG 2,4 X 1000MM	Tube	5	8720663419620
ALLOY 825 TIG 2,4 X 914MM	Tube	4,54	8720663419071
ALLOY 825 TIG 3,2 X 1000MM	Tube	5	8720663419668