
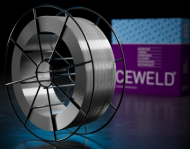


CEWELD Alloy 825

TYPE	Solid Nickel based welding wire for gas shielded 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 weldability 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	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiFeCr-1</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 8065(NiFe30Cr21Mo3)</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> <tr> <td>W.Nr.</td> <td>2.4858</td> </tr> </table>	AWS	A 5.14: ERNiFeCr-1	EN ISO	18274: S Ni 8065(NiFe30Cr21Mo3)	F-nr	43	FM	6	W.Nr.	2.4858										
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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 (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Ti</th> <th>Fe</th> <th>Cu</th> <th>Al</th> </tr> </thead> <tbody> <tr> <td>0.05</td> <td>0.3</td> <td>0.8</td> <td>22</td> <td>42</td> <td>3</td> <td>1</td> <td>30</td> <td>2</td> <td>0.1</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Cu	Al	0.05	0.3	0.8	22	42	3	1	30	2	0.1
C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Cu	Al												
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ALL WELD MECHANICAL PROPERTIES	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} MPa</th> <th rowspan="2">R_m MPa</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> </tr> <tr> <th colspan="2">-196°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>425</td> <td>630</td> <td>30</td> <td colspan="2">70</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A ₅ (%)	Impact Energy (J) ISO-V		-196°C		As Welded /	425	630	30	70							
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		-196°C																			
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REDRYING TEMPERATURE	Not required																				
GAS ACCORDING EN 14175	I1																				



CEWELD Alloy 825

ALLOY 825 1,2MM

Type	KG/unit	EANCode
BS-300	13,6	8720663419064
BS-300	13,6	8720663419606