




# CEWELD AA NiCr 625

TYPE	Rutile flux-cored nickel based welding wire for gas shielded arc welding.								
APPLICATIONS	AA Nicro 625 is developed for welding and cladding nickel-based alloys such as Inconel 625 or similar materials. This alloy can also be used for welding dissimilar nickel-based alloys to each other, to alloyed steels, to stainless steels and for joining 9% Nickel steels.								
PROPERTIES	Latest generation rutile flux cored wire, guarantees optimum metallurgical quality, economic positional welding and attractive welder appeal.Very good resistance against pitting corrosion and crevice corrosion.Very good against acid, neutral or alkaline media, with or without chlorides.Very good resistance at high temperatures, especially against oxidation.								
CLASSIFICATION	AWS	A 5.34: E NiCrMo3T1-4							
	EN ISO	12153-A: T Ni 6625 (NiCr22Mo9Nb) P M21 2							
	F-nr	43							
	FM	6							
	W.Nr.	2.4831							
SUITABLE FOR	<b>Ni 6625 / NiCr22Mo9Nb / 2.4831</b> <b>W.Nr:</b> 1.4529, 1.4539, 1.4547, 1.4876, 1.4958, 1.5656, 2.4660, 2.4816, 2.4856, 2.4858,  X1CrNiMoCuN20-18-7 - X10NiCrAlTi32-20 - X5NiCrAlTi31-20 - NiCr15Fe - NiCr22Mo9Nb - NiCr21Mo - X1NiCrMoCuN25 20 6 - X1NiCrMoCuN25 20 5 - NiCr21Mo - 8XNi9 <b>ASTM:</b> A 533 Gr1 <b>UNS:</b> S31254 - N08800 - N08810 - N06600 - N06625 - N08825 - N08926 - N08020 Alloy 254 SMO - Alloy 800 - Alloy 800H - Alloy 600 - Alloy 625 - Alloy 825 - Sanicro 28								
APPROVALS	No Approvals Found								
WELDING POSITIONS									
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo	Nb	Fe	S
	0.03	0.35	0.45	21.5	60.9	9.5	3.5	4	0.01
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R <sub>P0,2</sub> MPa	R <sub>m</sub> MPa	A <sub>5</sub> (%)	0°C	Impact Energy (J) ISO-V			
	As Welded /	500	780	40	84	-100°C		-196°C	
						78		70	
REDRYING TEMPERATURE	140°C / 24 hr								
GAS ACCORDING EN 14175	M21								



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AA NICRO 625 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663418821