



# CEWELD AA NiCrO 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** **Ni 6625 / NiCr22Mo9Nb / 2.4831**  
**W.Nr:** 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

**ASTM:** A 533 Gr1  
**UNS:** 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



**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	
					-100°C	-196°C
As Welded /	500	780	40	84	78	70

**REDRYING TEMPERATURE** 140°C / 24 hr

**GAS ACCORDING EN 14175** M21



# CEWELD AA NiCro 625

AA NICRO 625 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663418821