certilas® THE FILLER METAL SPECIALIST

CEWELD AA NiCro 625B

TYPE

Basic flux-cored nickel base welding wire for gas shielded arc welding.

APPLICATIONS

AA Nicro 625B is developed for welding and cladding nickel-based alloys such as alloy 625 or similar materials. This alloy can also be used for welding dissimilar nickel-based alloys to each other, to alloyed steels or to stainless steels and for joining 6% molybdenum super austenitic steels.

PROPERTIES

Latest generation basic slag guarantees optimum metallurgical quality and attractive welder appeal. The weld deposit meets the NiCrMo-3 requirements.Better bead aspect and shape compare to solid wires with better arc stability and improved wetting properties with less spatters.

CLASSIFICATION

AWS	A 5.34: E NiCrMo3T1-4
EN ISO	12153-A: T Ni 6625 (NiCr22Mo9Nb) B M21 3
F-nr	43
FM	6

SUITABLE FOR

Ni 6625 / NiCr22Mo9Nb / 2.4831
1.4547 - 1.4876 - 1.4958 - 2.4816 - 2.4856 - 2.4858 - 1.5656 - 1.4529 - 1.4539 - 2.4660
X1CrNiMoCuN20-18-7 - X10NiCrAlTi32-20 - X5NiCrAlTi31-20 - NiCr15Fe - NiCr22Mo9Nb - NiCr21Mo - X1NiCrMoCuN25 20 6 - X1NiCrMoCuN25 20 5 - NiCr21Mo - 8XNi9
UNS: S31254 - N08800 - N08810 - N06600 - N06625 - N08825 - N08926 - N08020
ASTM A 553 Gr.1, Alloy 600, Alloy 600 L, Alloy 625, Alloy 800 / 800H, Alloy 825
Alloy 254 SM - 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	60.5	9.5	3.4	4	0.01

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -196°C
As Welded /	500	780	40	60

REDRYING TEMPERATURE

140°C / 24 hr

GAS ACCORDING EN 14175

M21