



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	<table border="0"> <tr> <td>AWS</td> <td>A 5.34: E NiCrMo3T1-4</td> </tr> <tr> <td>EN ISO</td> <td>12153-A: T Ni 6625 (NiCr22Mo9Nb) B M21 3</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.34: E NiCrMo3T1-4	EN ISO	12153-A: T Ni 6625 (NiCr22Mo9Nb) B M21 3	F-nr	43	FM	6										
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SUITABLE FOR	<p>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</p>																		
APPROVALS	No Approvals Found																		
WELDING POSITIONS																			
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Nb</th> <th>Fe</th> <th>S</th> </tr> </thead> <tbody> <tr> <td>0.03</td> <td>0.35</td> <td>0.45</td> <td>21.5</td> <td>60.5</td> <td>9.5</td> <td>3.4</td> <td>4</td> <td>0.01</td> </tr> </tbody> </table>	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
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ALL WELD MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th>Heat Treatment</th> <th>R_{P0,2} MPa</th> <th>R_m MPa</th> <th>A5 (%)</th> <th>Impact Energy (J) ISO-V -196°C</th> </tr> </thead> <tbody> <tr> <td>As Welded /</td> <td>500</td> <td>780</td> <td>40</td> <td>60</td> </tr> </tbody> </table>	Heat Treatment	R _{P0,2} MPa	R _m MPa	A5 (%)	Impact Energy (J) ISO-V -196°C	As Welded /	500	780	40	60								
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REDRYING TEMPERATURE	140°C / 24 hr																		
GAS ACCORDING EN 14175	M21																		