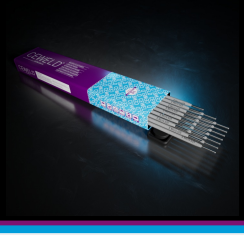


# CEWELD E NiCro 625

certilas® THE FILLER METAL SPECIALIST

**TYPE**

Latest generation with vacuum-melted core wire, guarantees optimum metallurgical quality. (Type 6625, ENiCrMo-3)

**APPLICATIONS**

**CEWELD® E NiCro 625** is developed for 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, to stainless steels and for joining 9% Nickel steels.

**PROPERTIES**

**CEWELD® E NiCro 625** have a 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 5.11: E NiCrMo-3 |
| EN ISO | 14172: E Ni 6625 (NiCr22Mo9Nb) |
| F-nr | 43 |
| FM | 6 |
| W.Nr. | 2.4621 |

**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 254SMO - Alloy 800 - Alloy 800H - Alloy 600 - Alloy 625 - Alloy 825 - Sanicro 28 - 6Mo

**APPROVALS**

No Approvals Found

**WELDING POSITIONS**


**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C | Si | Mn | Cr | Ni | Mo | Fe | Nb+Ta | Nb |
|---|---|---|---|---|---|---|---|---|
| 0.09 | 0.6 | 0.8 | 22 | 60 | 9 | 5 | 4 | 3.8 |

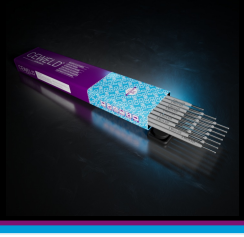
**ALL WELD MECHANICAL PROPERTIES**

| Heat Treatment | $R_{P0,2}$ MPa | Rm MPa | A5 (%) | Impact Energy (J) ISO-V RT | Impact Energy (J) ISO-V -196°C |
|---|---|---|---|---|---|
| As Welded / | 450 | 785 | 38 | 80 | 65 |

**REDRYING TEMPERATURE**

300°C / 2 hr

**GAS ACCORDING EN 14175**



# CEWELD E NiCro 625

certilas® THE FILLER METAL SPECIALIST

| | Type | KG/unit | EANCode |
|---|---|---|---|
| E NICRO 625 2,4 X 300MM | Can | 2,27 | 8720663418777 |
| E NICRO 625 3,2 X 356MM | Can | 2,27 | 8720663418784 |
| E NICRO 625 4,0 X 356MM | Can | 2,27 | 8720663418791 |
| E NICRO 625 4,8 X 356MM | Can | 2,27 | 8720663418807 |