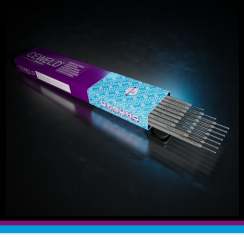


CEWELD E NiCro 625 HLS

certilas® THE FILLER METAL SPECIALIST

TYPE

Nickel based high recovery electrode

APPLICATIONS

CEWELD® E NiCro 625 HLS 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

Latest generation high recovery type (170%) guarantees optimum deposit rate and metallurgical quality and attractive welder appeal in the PA-PB position. 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 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	Fe	Nb+Ta	Nb
0.08	0.6	0.7	22	60	9	5	4	3.8

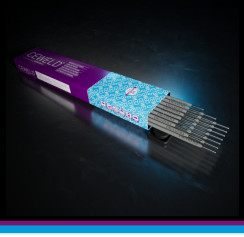
ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V RT	Impact Energy (J) ISO-V -196°C
As Welded /	455	795	37	78	60

REDRYING TEMPERATURE

300°C / 2 hr

GAS ACCORDING EN 14175



CEWELD E NiCro 625 HLS

certilas® THE FILLER METAL SPECIALIST

	Type	KG/unit	EANCode
E NICRO 625 HLS 2,5 X 350MM	Can	2,27	8720663418746

	Type	KG/unit	EANCode
E NICRO 625 HLS 3,2 X 350MM	Can	2,27	8720663418753

	Type	KG/unit	EANCode
E NICRO 625 HLS 4,0 X 350MM	Can	2,27	8720663418760