



CEWELD E NiCro 625 HLS

certilas® THE FILLER METAL SPECIALIST

TYPE	Nickel based high recovery electrode. (Type 6625, ENiCrMo-3)																													
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	CEWELD® E NiCro 625 HLS 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. High recovery of 140%																													
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, B443, B444, B446 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 (%)	<table border="1"> <tr> <td>C</td><td>Si</td><td>Mn</td><td>Cr</td><td>Ni</td><td>Mo</td><td>Fe</td><td>Nb+Ta</td><td>Nb</td><td></td></tr> <tr> <td>0.08</td><td>0.6</td><td>0.7</td><td>22</td><td>60</td><td>9</td><td>5</td><td>4</td><td>3.8</td><td></td></tr> </table>										C	Si	Mn	Cr	Ni	Mo	Fe	Nb+Ta	Nb		0.08	0.6	0.7	22	60	9	5	4	3.8	
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	<table border="1"> <thead> <tr> <th>Heat Treatment</th><th>R_{P0,2} MPa</th><th>R_m MPa</th><th>A₅ (%)</th><th>RT</th><th>Impact Energy (J) ISO-V -196°C</th></tr> </thead> <tbody> <tr> <td>As Welded /</td><td>455</td><td>795</td><td>37</td><td>78</td><td>60</td></tr> </tbody> </table>										Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	RT	Impact Energy (J) ISO-V -196°C	As Welded /	455	795	37	78	60								
Heat Treatment	R _{P0,2} MPa	R _m MPa	A ₅ (%)	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

E NICRO 625 HLS 2,5 X
350MM

Type	KG/unit	EANCode
Can	2,27	8720663418746

E NICRO 625 HLS 3,2 X
350MM

Type	KG/unit	EANCode
Can	2,27	8720663418753

E NICRO 625 HLS 4,0 X
350MM

Type	KG/unit	EANCode
Can	2,27	8720663418760