





TYPE Mig welding wire for Inconel 625

APPLICATIONS CEWELD® NiCro 625 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. Alloy 625 is most commonly used in the chemical processing industry, pollution control equipment, marine equipment, nuclear reactor components, pump shafts. Also used in the aerospace industry

for thrust reverser assemblies, fuel nozzles, after-burners and combustion systems.

PROPERTIES CEWELD® Nicro 625 is a solid drawn wire that is cleaned in a very special way to obtain cleaner and

higher quality welds, especially when used for the Hotwire Tig process intermediate cleaning between the layers can be skipped and results in a bright seam with excellent ductility. The cast and helix of this wire are kept above the EN standards to offer excellent wire feeding and a wire that

comes straight out of the torch.

CLASSIFICATION AWS A 5.14: ERNiCrMo-3

> EN ISO 18274: S Ni 6625 (NiCr22Mo9Nb)

F-nr 43 FΜ W.Nr. 2.4831

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 - AL6XN - 6Mo

APPROVALS TÜV (12400.0)

WELDING POSITIONS

TYPICAL CHEMICAL

Si Cr Mn ANALYSIS OF THE FILLER 0.4 METAL (%)

ALL WELD MECHANICAL **PROPERTIES**

 $R_{P0.2}$ A5 Impact Energy (J) ISO-V Heat Rm -20°C MPa MPa (%)-196°C Treatment As Welded / 460 750 32 110 70

REDRYING TEMPERATURE Not required

GAS ACCORDING EN 14175 11 Nb+Ta

3.8





CEWELD NiCro 625

NICRO 625 1,6MM	Type	KG/unit	EANCode	
•	BS-300	15	8720663419361	_
NICRO 625 1,2MM	Type	KG/unit	EANCode	
	Drum	250	8720663419347	
NICRO 625 1,14MM	Type	KG/unit	EANCode	
	BS-300	15	8720663419309	_
NICRO 625 1,0MM	Type	KG/unit	EANCode	
	BS-300	15	8720663419286	
NICRO 625 0,8MM	Type	KG/unit	EANCode	
	BS-300	15	8720663419262	_