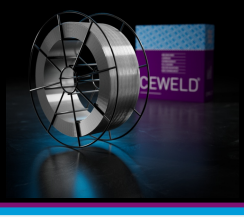


CEWELD NiCro 625

certilas® THE FILLER METAL SPECIALIST

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
FM	6
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))

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo	Nb	Fe	Nb+Ta
0.08	0.4	0.4	21	63	9	3.8	3	3.8

ALL WELD MECHANICAL PROPERTIES

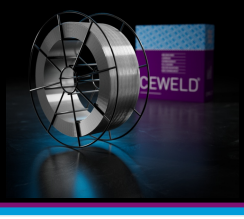
Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)	Impact Energy (J) ISO-V -20°C	Impact Energy (J) ISO-V -196°C
As Welded /	460	750	32	110	70

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175

I1



CEWELD NiCro 625

certilas® THE FILLER METAL SPECIALIST

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