



CEWELD AA NiCrO 625

TYPE Rutile flux-cored nickel based welding wire for gas shielded arc welding.

ANWENDUNGEN AA Nicro 625 is developed for welding and cladding nickel-based alloys such as Inconel 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.

EIGENSCHAFTEN Latest generation rutile flux cored wire, guarantees optimum metallurgical quality, economic positional welding and attractive welder appeal. 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.

KLASSIFIKATION

| | |
|--------|--|
| AWS | A 5.34: E NiCrMo3T1-4 |
| EN ISO | 12153-A: T Ni 6625 (NiCr22Mo9Nb) P M21 2 |
| W.Nr. | 2.4831 |
| F-nr | 43 |
| FM | 6 |

GEEIGNET FÜR **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

ZULASSUNGEN

SCHWEISSPOSITIONEN



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | Cr | Ni | Mo | Nb | Fe | S |
|------|------|------|------|------|-----|-----|----|------|
| 0.03 | 0.35 | 0.45 | 21.5 | 60.9 | 9.5 | 3.5 | 4 | 0.01 |

MECHANISCHE GÜTEWERTE

| Heat Treatment | R _{P0,2} (MPa) | R _m (MPa) | A ₅ (%) | Impact Energy (J) ISO-V | | | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|--------|----------|
| | | | | 0°C | -100°C | -196°C | |
| As Welded | 500 | 780 | 40 | 84 | 78 | 70 | HRc |

RÜCKTROCKNUNG 140°C / 24 hr

GAS ACC. EN ISO 14175 M21



CEWELD AA NiCro 625

AA NICRO 625 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| BS-300 | 15 | 8720663418821 |