certilas® THE FILLER METAL SPECIALIST

CEWELD AA NiCro 625

TYPE

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

APPLICATIONS

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.

PROPERTIES

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.

CLASSIFICATION

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

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

WELDING POSITIONS

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

MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness
				0°C	-100°C	-196°C	
As Welded	500	780	40	84	78	70	HRc

REDRYING

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