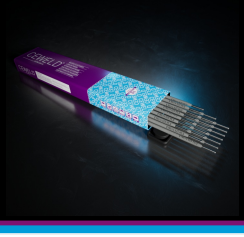


CEWELD E NiCro 625 HLS

certilas® THE FILLER METAL SPECIALIST

TYPE

Nickel based high recovery electrode

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.

PROPRIÉTÉS

Latest generation high recovery type (170%) guarantees optimum deposit rate and metallurgical quality and attractive welder appeal in the PA-PB position. 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 5.11: E NiCrMo-3
EN ISO	14172: E Ni 6625 (NiCr22Mo9Nb)
W.Nr.	2.4621
F-nr	43
FM	6

CONVIENT POUR

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 254 SMO - Alloy 800 - Alloy 800H - Alloy 600 - Alloy 625 - Alloy 825 - Sanicro 28

AGRÉMENTS

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Cr	Ni	Mo	Fe	Nb+Ta	Nb
0.08	0.6	0.7	22	60	9	5	4	3.8

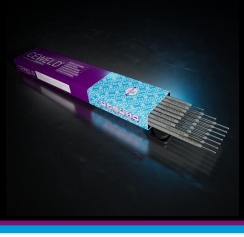
PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	455	795	37	78	60	HRc

ETUVAGE

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E NiCro 625 HLS

certilas® THE FILLER METAL SPECIALIST

E NICRO 625 HLS 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418746

E NICRO 625 HLS 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418753

E NICRO 625 HLS 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418760