CEWELD NiCro 625 Tig

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid nickel base welding rod for tungsten inert gas welding

ANWENDUNGEN

CEWELD® NiCro 625 Tig 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. Nicro 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.

EIGENSCHAFTEN

CEWELD® Nicro 625 is a solid drawn wire that is cleaned in a very special way to obtain cleaner and higher quality welds with a bright seam and excellent ductility. Long term use at working temperatures between 600°C and 800°C should be avoided.

KLASSIFIKATION

AWS	A 5.14: ERNiCrMo-3
EN ISO	18274: S Ni 6625 (NiCr22Mo9Nb)
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 254SMO - Alloy 800 - Alloy 800H - Alloy 600 - Alloy 625 - Alloy 825 - Sanicro 28 - AL6XN - 6Mo

ZULASSUNGEN

TÜV: (12400)

SCHWEISSPOSITIONEN

TYPISCHE CHEMISCHE ANALYSE DES FÜLLMETALLS (%)

C	Si	Mn	Cr	Ni	Mo	Fe	Nb+Ta
0.08	0.07	0.4	21	65	9	0.5	3.8

MECHANISCHE GÜTEWERTE

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

RÜCKTROCKNUNG

Not required

GAS ACC. EN ISO 14175

I1

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	Packaging	KG/unit	EanCode
NICRO 625 TIG 1,0 X 1000MM	Tube	5	8720663418852
NICRO 625 TIG 1,2 X 1000MM	Tube	5	8720663418869
NICRO 625 TIG 1,6 X 1000MM	Tube	5	8720663418876
NICRO 625 TIG 1,6 X 914MM	Tube	4,54	8720663418883
NICRO 625 TIG 2,0 X 1000MM	Tube	5	8720663418890
NICRO 625 TIG 2,0 X 914MM	Tube	4,54	8720663418906
NICRO 625 TIG 2,4 X 1000MM	Tube	5	8720663418913
NICRO 625 TIG 2,4 X 914MM	Tube	4,54	8720663419040
NICRO 625 TIG 3,2 X 1000MM	Tube	5	8720663418920
NICRO 625 TIG 3,2 X 914MM	Tube	4,54	8720663418937