



# CEWELD E NiCrMo 625

**TYPE** Latest generation with vacuum-melted core wire, guarantees optimum metallurgical quality. (Type 6625, ENiCrMo-3)

**APPLICATIONS** CEWELD® E NiCrMo 625 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.

**PROPERTIES** CEWELD® E NiCrMo 625 have a 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                              |

**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 | Fe | Nb+Ta | Nb  |
|------|-----|-----|----|----|----|----|-------|-----|
| 0.09 | 0.6 | 0.8 | 22 | 60 | 9  | 5  | 4     | 3.8 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
|                |                         |                      |                    | RT                      | -196°C |          |
| As Welded      | 450                     | 785                  | 38                 | 80                      | 65     | HRC      |

**REDRYING** 300°C / 2 hr

**GAS ACC.** EN ISO 14175



# CEWELD E NiCro 625

|                         |           |         |               |
|-------------------------|-----------|---------|---------------|
| E NiCRO 625 2,4 X 300MM | Packaging | KG/unit | EanCode       |
|                         | Can       | 2,27    | 8720663418777 |
| E NiCRO 625 3,2 X 356MM | Packaging | KG/unit | EanCode       |
|                         | Can       | 2,27    | 8720663418784 |
| E NiCRO 625 4,0 X 356MM | Packaging | KG/unit | EanCode       |
|                         | Can       | 2,27    | 8720663418791 |
| E NiCRO 625 4,8 X 356MM | Packaging | KG/unit | EanCode       |
|                         | Can       | 2,27    | 8720663418807 |