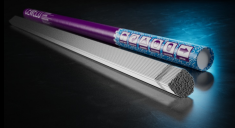


CEWELD NiCro 625 Tig

TYPE	Tig filler metal for welding Inconel 625 and similar alloys																
APPLICATIONS	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.																
PROPERTIES	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.																
CLASSIFICATION	<table border="0"> <tr> <td>AWS</td> <td>A 5.14: ERNiCrMo-3</td> </tr> <tr> <td>EN ISO</td> <td>18274: S Ni 6625 (NiCr22Mo9Nb)</td> </tr> <tr> <td>W.Nr.</td> <td>2.4831</td> </tr> <tr> <td>F-nr</td> <td>43</td> </tr> <tr> <td>FM</td> <td>6</td> </tr> </table>	AWS	A 5.14: ERNiCrMo-3	EN ISO	18274: S Ni 6625 (NiCr22Mo9Nb)	W.Nr.	2.4831	F-nr	43	FM	6						
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EN ISO	18274: S Ni 6625 (NiCr22Mo9Nb)																
W.Nr.	2.4831																
F-nr	43																
FM	6																
SUITABLE FOR	<p>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,</p> <p>X1CrNiMoCuN20-18-7 - X10NiCrAlTi32-20 - X5NiCrAlTi31-20 - NiCr15Fe - NiCr22Mo9Nb - NiCr21Mo - X1NiCrMoCuN25 20 6 - X1NiCrMoCuN25 20 5 - NiCr21Mo - 8XNi9</p> <p>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 - AL6XN</p>																
APPROVALS	TÜV: 12400.00																
WELDING POSITIONS																	
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table border="1"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Fe</th> <th>Nb+Ta</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.07</td> <td>0.4</td> <td>21</td> <td>65</td> <td>9</td> <td>0.5</td> <td>3.8</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	Fe	Nb+Ta	0.08	0.07	0.4	21	65	9	0.5	3.8
C	Si	Mn	Cr	Ni	Mo	Fe	Nb+Ta										
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MECHANICAL PROPERTIES	<table border="1"> <thead> <tr> <th rowspan="2">Heat Treatment</th> <th rowspan="2">R_{p0,2} (MPa)</th> <th rowspan="2">R_m (MPa)</th> <th rowspan="2">A₅ (%)</th> <th colspan="2">Impact Energy (J) ISO-V</th> <th rowspan="2">Hardness</th> </tr> <tr> <th>RT</th> <th>-196°C</th> </tr> </thead> <tbody> <tr> <td>As Welded</td> <td>460</td> <td>750</td> <td>32</td> <td>110</td> <td>70</td> <td>HRc</td> </tr> </tbody> </table>	Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V		Hardness	RT	-196°C	As Welded	460	750	32	110	70	HRc
Heat Treatment	R _{p0,2} (MPa)					R _m (MPa)	A ₅ (%)		Impact Energy (J) ISO-V		Hardness						
		RT	-196°C														
As Welded	460	750	32	110	70	HRc											
REDRYING	Not required																
GAS ACC. EN ISO 14175	I1																



CEWELD NiCro 625 Tig

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