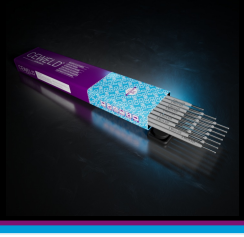


CEWELD E NiCro 625

certilas® THE FILLER METAL SPECIALIST

TYPE

Latest generation clean quality (vacuum melted core wire) guarantees optimum metallurgical quality and attractive welder appeal.

ANWENDUNGEN

CEWELD E NiCro 625 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, to stainless steels and for joining 9% Nickel steels.

EIGENSCHAFTEN

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.

KLASSIFIKATION

AWS	A 5.11: E NiCrMo-3
EN ISO	14172: E Ni 6625 (NiCr22Mo9Nb)
W.Nr.	2.4621
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 254 SMO - Alloy 800 - Alloy 800H - Alloy 600 - Alloy 625 - Alloy 825 - Sanicro 28

ZULASSUNGEN

SCHWEISSPOSITIONEN

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

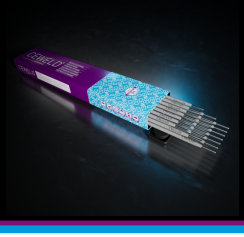
MECHANISCHE GÜTEWERTE

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	450	785	38	80	65	HRc

RÜCKTROCKNUNG

300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E NiCro 625

certilas® THE FILLER METAL SPECIALIST

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