


CEWELD NiCro 625

TYPE	Solid nickel base welding wire for gas shielded arc welding.																		
ANWENDUNGEN	CEWELD® 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 or to stainless steels and for joining 6% molybdenum super austenitic steels. Alloy 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, especially when used for the Hotwire Tig process intermediate cleaning between the layers can be skipped and results in a bright seam with excellent ductility. The cast and helix of this wire are kept above the EN standards to offer excellent wire feeding and a wire that comes straight out of the torch.																		
KLASSIFIKATION	<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								
AWS	A 5.14: ERNiCrMo-3																		
EN ISO	18274: S Ni 6625 (NiCr22Mo9Nb)																		
W.Nr.	2.4831																		
F-nr	43																		
FM	6																		
GEEIGNET FÜR	<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 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</p>																		
ZULASSUNGEN	TÜV: 12400.0																		
SCHWEISSPOSITIONEN																			
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>Nb</th> <th>Fe</th> <th>Nb+Ta</th> </tr> </thead> <tbody> <tr> <td>0.08</td> <td>0.4</td> <td>0.4</td> <td>21</td> <td>63</td> <td>9</td> <td>3.8</td> <td>3</td> <td>3.8</td> </tr> </tbody> </table>	C	Si	Mn	Cr	Ni	Mo	Nb	Fe	Nb+Ta	0.08	0.4	0.4	21	63	9	3.8	3	3.8
C	Si	Mn	Cr	Ni	Mo	Nb	Fe	Nb+Ta											
0.08	0.4	0.4	21	63	9	3.8	3	3.8											
MECHANISCHE GÜTEWERTE	<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>-20°C</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	-20°C	-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								
		-20°C	-196°C																
As Welded	460	750	32	110	70	HRc													
RÜCKTROCKNUNG	Not required																		
GAS ACC. EN ISO 14175	I1																		