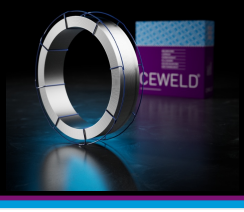


CEWELD SA Nicro 625

certilas® THE FILLER METAL SPECIALIST

TYPE

Nickel - Chromium - Molybdenium alloy for SAW welding.

APPLICATIONS

SA 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.. SA 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

SA Nicro 625 is a solid drawn wire to be used for the submerged arc process in combination with our fused flux FL 880 or agglomerated flux FL 838 or FL 839.

CLASSIFICATION

AWS	A 5.14: ERNiCrMo-3
EN ISO	18274: S Ni 6625 (NiCr22Mo9Nb)
W.Nr.	2.4831
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 THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo	Nb	Ti	Fe
0.04	0.5	0.5	22	68	9	3.9	0.2	3

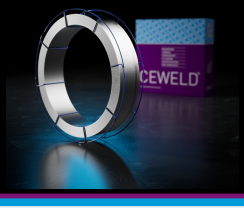
MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	470	770	35	80	50	HRc

REDRYING

Not required

GAS ACC. EN ISO 14175



CEWELD SA Nicro 625

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SA NICRO 625 1,6MM

Packaging	KG/unit	EanCode
K-415	25	8720663412034

SA NICRO 625 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663412041

SA NICRO 625 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663412058