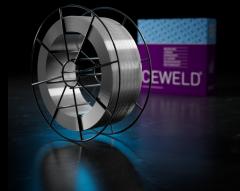


# CEWELD Alloy 825

TYPE	Solid Nickel based welding wire for gas shielded arc welding																																							
APPLICATIONS	The excellent corrosion-resistant properties of CEWELD Alloy 825 make the alloy a suitable choice for a variety of difficult applications. Uses include fabricated equipment found in chemical and petro-chemical processing, pulp and paper manufacturing, flue gas desulphurization systems and metal pickling operations.																																							
PROPRIÉTÉS	Excellent weldability with fully austenitic weld metal with high resistance against stress corrosion cracking and pitting in media containing chloride ions. Good corrosion resistance against reducing acids due to the combination of Ni, Mo and Cu. Sufficient resistance against oxidizing acids. The weld metal is corrosion resistant in sea water.																																							
CLASSIFICATION	<table><tr><td>AWS</td><td>A 5.14: ERNiFeCr-1</td></tr><tr><td>EN ISO</td><td>18274: S Ni 8065(NiFe30Cr21Mo3)</td></tr><tr><td>W.Nr.</td><td>2.4858</td></tr><tr><td>F-nr</td><td>43</td></tr><tr><td>FM</td><td>6</td></tr></table>										AWS	A 5.14: ERNiFeCr-1	EN ISO	18274: S Ni 8065(NiFe30Cr21Mo3)	W.Nr.	2.4858	F-nr	43	FM	6																				
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CONVIENT POUR	G-X7NiCrMoCuNb25-20, X1NiCrMoCuN25-20-6, X1NiCrMoCuN25-20-5, NiCr21Mo, X1NiCrMoCu31-27-4, N08926, N08904, N08028, N08825 ALLOY 825 1.4500, 1.4529, 1.4539 (904L), 2.4858, 1.4563, 1.4465, 1.4577 (310Mo), 1.4133, 1.4500, 1.4503, 1.4505, 1.4506, 1.4531, 1.4536, 1.4585, 1.4586																																							
AGRÉMENTS																																								
POSITIONS DE SOUDAGE																																								
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table><tr><td>C</td><td>Si</td><td>Mn</td><td>Cr</td><td>Ni</td><td>Mo</td><td>Ti</td><td>Fe</td><td>Cu</td><td>Al</td></tr><tr><td>0.05</td><td>0.3</td><td>0.8</td><td>22</td><td>42</td><td>3</td><td>1</td><td>30</td><td>2</td><td>0.1</td></tr></table>										C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Cu	Al	0.05	0.3	0.8	22	42	3	1	30	2	0.1										
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PROPRIÉTÉS MÉCANIQUES	<table><thead><tr><th>Heat Treatment</th><th>R<sub>P0,2</sub> (MPa)</th><th>R<sub>m</sub> (MPa)</th><th>A5 (%)</th><th colspan="3">Impact Energy (J) ISO-V</th><th colspan="3">Hardness</th></tr><tr><th>As Welded</th><th>425</th><th>630</th><th>30</th><th colspan="3">-196°C</th><th colspan="3">HRc</th></tr></thead><tbody><tr><td></td><td></td><td></td><td></td><td colspan="3">70</td><td colspan="3"></td></tr></tbody></table>										Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A5 (%)	Impact Energy (J) ISO-V			Hardness			As Welded	425	630	30	-196°C			HRc							70					
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As Welded	425	630	30	-196°C			HRc																																	
				70																																				
ETUVAGE	Not required																																							
GAS ACC. EN ISO 14175	I1																																							



# CEWELD Alloy 825

ALLOY 825 1,2MM

Packaging	KG/unit	EanCode
BS-300	13,6	8720663419064
BS-300	13,6	8720663419606