



# CEWELD E NiCr 825

**TYPE** Rutile-basic nickel based electrode for DC+ and AC current

**APPLICATIONS** The excellent corrosion-resistant properties of 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**

AWS	636-A: E Ni 8025 (NiCr29Fe30Mo)
EN ISO	14172: E Ni 8165
W.Nr.	2.4652
FM	6

**CONVIENT POUR** G-X7NiCrMoCuNb 25 20, X1NiCrMoCuN25 20 6, X1NiCrMoCuN25 20 5, NiCr21Mo, X1NiCrMoCu 31 27 4, N08926, N08904, ALLOY 825, N08028, UNS N08825 W.Nr: 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 WELD METAL (%)**

C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Cu
0.02	0.5	2	25	40	5.5	0.2	25	2

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0,2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V	Hardness
				-196°C	
As Welded	425	630	30	70	HRc

**ETUVAGE** 300°C / 2 hr

**GAS ACC. EN ISO 14175**