

MIG Ni625



Classification

EN 18274 : S-NiCr22Mo9Nb Material N° : 2.4831
AWS A5.14 : ERNiCrMo-3 DIN 1736 : SG Ni Cr 21 Mo 9 Nb

Description & Applications

Solid wire for used for GMAW of high nickel alloys as well as for special austenitic stainless steels. Used in the construction of equipment submitted to oxidizing and corrosive attacks. Excellent resistance to pitting, crevice and stress corrosion cracking in the presence of chlorides. Highly resistant at low temperatures, therefore also applied to weld 9% Ni steels.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	Fe	Nb	P	S	Ni
0.02	0.2	0.2	22.0	9.0	1.0	3.5	<0.02	<0.01	base

All Weld Metal Mechanical Properties

Rp0,2 (MPa)	Rm (MPa)	A5 (%)	KV (J)
450	760	40	+ 20°C : 140 - 196°C : 70

Welding Current & Instructions

Welding mode	Ø wire (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
MIG	0.8	80-140	23-27	Ar
=+	1.0	90-160	24-28	Ar + He
	1.2	160-200	24-28	Ar/He + 0.05% CO ²
	1.6	180-260	24-28	18-20 l/min



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