

E Nicro 625 HLS

CATEGORY	SMAW Stick Electrodes
TYPE	Nickel based high recovery electrode.
APPLICATIONS	Nicro 625 HLS is developed for 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, to stainless steels and for joining 9% Nickel steels.
PROPERTIES	<p>Latest generation high recovery type (170%) guarantees optimum deposit rate and metallurgical quality and attractive welder appeal in the PA-PB position.</p> <p>Very good resistance against pitting corrosion and crevice corrosion.</p> <p>Very good against acid, neutral or alkaline media, with or without chlorides.</p> <p>Very good resistance at high temperatures, especially against oxidation.</p>
CLASSIFICATION	<p>AWS A 5.11: E NiCrMo-3</p> <p>EN ISO 14172:</p> <p>DIN: W.Nr. 2.4831</p> <p>DIN 1736: EL-NiCr20Mo9Nb</p>
SUITABLE FOR	X10NiCrAlTi, 32-20H, 32-21, X8 Ni9, ASTM A 533 Gr1, 800H, Sanicro 28, 254SMo, inconel 625, UNS : N08926, N08825, N06625. DIN : X8Ni9, X1NiCrMoCuN25 20 6, X1NiCrMoCuN25 20 5, NiCr21Mo, NiCr22Mo9Nb W.Nr.: 1.4876, 1.5656, 1.4529, 2.4858, 2.4856, 1.4539, 1.4547

WELDING POSITIONS:



Ni+Co	C	Mn	Fe	S	Si	Cu	Cr	Nb+Ta	Mo	P	Other
> 55.0	< 0.06	< 1.0	< 7.0	< 0.02	< 0.75	< 0.50	19.0-21.0	2.0-4.0	8.0-11.0	< 0.03	0.50

MECHANICAL PROPERTIES

Heat Treatment	R _{p0.2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				20°C	-40°C	-196°C	
AW	> 450	> 760	> 30	> 75		> 45	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
2.5	350	60-90			
3.2	350	80-110			
4.0	350	100-150			
5.0	450	150-220			