

AA Nicro 625

CATEGORY FCAW Flux-Cored

TYPE Rutile flux-cored nickel based welding wire for gas shielded arc welding.

APPLICATIONS AA Nicro 625 is developed for welding and cladding nickel-based alloys such as Inconel 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 Latest generation rutile flux cored wire, guarantees optimum metallurgical quality, economic positional welding and attractive welder appeal.
Very good resistance against pitting corrosion and crevice corrosion.
Very good against acid, neutral or alkaline media, with or without chlorides.
Very good resistance at high temperatures, especially against oxidation.

CLASSIFICATION

AWS	A 5.34: E NiCrMo3 T 1-4
EN ISO	12153: T Ni 6625 P M 2
DIN: W.Nr.	2.4831

SUITABLE FOR 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, to stainless steels and for joining 9% Nickel steels., X10NiCrAlTi, 32-20H, 32-21, X8 Ni9, ASTM A 533 Gr1, 800H, Sanicro 28, 254SMo, inconel 625, UNS : N08926, N08825, N06625, N08020. 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, 2.4660

APPROVALS CE approved

WELDING POSITIONS:



ALL-WELD METAL ANALYSES % (TYPICAL)

C	Mn	Si	Cr	Ni	Mo	Nb+Ta	Fe
0.030	0.41	0.36	21.6	60.8	9.1	3.4	4.1

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	440	750	35	110		60 J	

AW: as welded

WELDING PARAMETERS / PACKING

Position	Welding Parameters		Packing		
	Voltage (V)	Current (A)	Spools	kg/spool	kg/pallet
PF	22-29	120-180	BS-300	15	1080
PA	24-35	150-225	BS-300	15	1080

REDRYING TEMPERATURE 150°C / 24hr

GAS ACC. EN ISO 14175: M21