CEWELD®

AA Nicro 625B

CATEGORY	FCAW Flux-Cored
TYPE	Basic flux-cored nickel base welding wire for gas shielded arc welding.
APPLICATIONS	AA Nicro 625B 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 or to stainless steels and for joining 6% molybdenum super austenitic steels.
PROPERTIES	Latest generation basic slag guarantees optimum metallurgical quality and attractive welder appeal. The weld deposit meets the NiCrMo-3 requirements. Better bead aspect and shape compare to solid wires with better arc stability and improved wetting properties with less spatters.
CLASSIFICATION	AWS A 5.34: E NiCrMo-3T0-4 EN ISO 14172: ~Typ Ni 6625 (NiCr22Mo9Nb) DIN: W.Nr. 2.4321
SUITABLE FOR	AA 625B 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. 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
APPROVALS	CE approved
WELDING POSITIONS:	

ALL-WELD METAL ANALYSES %

C	Mn	Si	Cr	Ni	Mo	Nb	Fe
0.025	0.4	0.3	21.0	rem	9.0	3.4	0.40

ALL WELD METAL PROPERTIES (TYPICAL)

Heat Treatment	$R_{P0,2}$ (N/mm^2)	Rm (N/mm^2)	A5 (%)	Impact Energy (J) ISO-V -20°C	-40°C	-196°C	Hardness HRc / HV
AW	500	780	40			60	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.2	26-32	125-225	S-300	15	1080
1.6	27-34	150-260	S-300	15	1080

REDRYING TEMPERATURE	150°C / 24hr
GAS ACC. EN ISO 14175:	M21