

Applications

SR-625 is designed for welding of Inconel 600 + 625 and Nickel alloys, 9% Nickel steels. (LNG storage tank manufacture, desulfurization, Heat exchanger, Building of chemical carrier)

Characteristics on Usage

SR-625 has an Excellent corrosion resistance of Crevice and Pitting, SCC. it provides good tensile strength in high temperature

Notes on Usage

- ① Remove rust, scales, oil, paint, slag of tack welds.
- ② Keep the arc as short as possible.
- ③ Dry the electrodes at 300~350°C(572~662°F) for 60 minutes before use.
- ④ Keep the welding current as low as possible.

Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

AC or DC+

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Nb+Ta	Fe
0.06	0.35	0.001	0.001	0.003	21.21	62.61	9.2	3.58	3.5

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
772 (111,000)	32	-196 (-321)	48 (35)

Approval

ABS

I Packing

Packet 2.5 kg (5.5 lbs)
Carton 2.5 kg (5.5 lbs) × 4 : 10kg(22 lbs)

Sizes Available and Recommended Currents (Amp.)

Size mm(in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm(in)	300 (12)	350 (14)	350 (14)	350 (14)
F	90~95	100~105	120~140	140~180
V-up/OH	90~95	100~105	110~115	110~130