

## INCO-CORED® 625DH & 625AP Flux Cored Wires

**INCO-CORED 625DH and 625AP Flux Cored Wires** are companions to INCONEL Filler Metal 625 and INCONEL Welding Electrode 112. They offer excellent weldability in addition to the higher deposition rates associated with flux-cored wires. The 625DH is designed for flat and horizontal position welding, and the 625AP is designed for all-position operability. The recommended shielding gas is 75% Argon / 25% Carbon Dioxide.

These products provide a deposited weld chemistry equivalent to that achieved with INCONEL Filler Metal 625. The integrity of the weld deposit chemistry is assured by the fact that INCO-CORED 625 Flux Cored wires have a full alloy sheath.

The products are used to weld INCONEL alloy 625, INCOLOY alloy 825, INCOLOY alloy 25-6MO, and other molybdenum-containing stainless steels. They are also used for surfacing steel, the welding of nickel steels, and for welding various corrosion-resisting alloys such as alloy 20. The weld metal has high strength, and exceptional corrosion resistance, including resistance to localized attack such as pitting and crevice corrosion.

The 625DH and 625AP products are useful for making dissimilar metal welds involving INCONEL and INCOLOY alloys, carbon steels, low-alloy steels, and stainless steels. Power supply: direct current, electrode positive.

**Specifications** The products have been proposed to AWS and are expected to be listed in AWS A5.34 as ENiCrMo3T0-4 and ENiCrMo3T1-4. Other specifications will follow.

**Approvals** Please confirm details of current scope of approvals with the Technical Department prior to order placement.

Typical Chemical Composition (%)	Ni-Cr-Mo Filler Metal 625	
	625DH	625AP
Ni.....	64	0.04
Cr .....	20	0.1
Mo .....	9	<0.015
Nb .....	3.4	0.05
Fe .....	0.5	<0.02
Si.....	0.3	0.05
Mn .....	0.3	<0.5
		Others .....

Typical Mechanical Properties	Tensile Strength	
	psi	MPa
	110,000	758
	Elongation, (4d) %	
	45	

### Available Product Forms

mm	1.14	1.6
in	0.045	0.062

0.062 and 0.045 on level layer wound 30 lb. wire basket spools