## **CEWELD**<sup>®</sup>

## AA Nicro 625B

CATEGORY		Cored									
CATEGOIN	FCAW Flux-C	FCAW Flux-Cored									
ТҮРЕ	Basic flux-co	Basic flux-cored nickel base welding wire for gas shielded arc welding.									
APPLICATIONS	AA Nicro 62 materials. T or to stainle	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 gene deposit mee Better bead properties v	Latest generation basic slag guarantees optimum metallurgical quality and attractive welder appeal. The welc 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 EN ISO DIN: W.Nr.	A 5.34: E 14172: ~ 2.4321	A 5.34: E NiCrMo-3T0-4 14172: ~Typ Ni 6625 (NiCr22Mo9Nb) 2.4321								
SUITABLE FOR	AA 625B is o alloy can als steels and f 28, 254SMo X1NiCrMoCu 1.4547	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., X10NiCrAITi, 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									
	CE approve	CE approved									
APPROVALS											
WELDING POSITIONS:											
WELDING POSITIONS:	ALYSES %										
APPROVALS WELDING POSITIONS: ALL-WELD METAL ANA	ALYSES %	Si Si	Cr	Ni	Мо	Nb	Fe				
WELDING POSITIONS: ALL-WELD METAL ANA C 0.025	ALYSES %	Si O.3	Cr 21.0	Ni rem	<u>Mo</u> 9.0	Nb 3.4	Fe 0.40				
WELDING POSITIONS: ALL-WELD METAL ANA C 0.025 ALL WELD METAL PRC	ALYSES % Mn 0.4 PERTIES (TYPICAL)	Si 0.3	Cr 21.0	Ni rem	Мо 9.0	Nb 3.4	Fe 0.40				
WELDING POSITIONS: ALL-WELD METAL ANA C 0.025 ALL WELD METAL PRO Heat	MLYSES % Mn 0.4 PPERTIES (TYPICAL)	Si 0.3	Cr 21.0	Ni rem	Mo 9.0 nergy (J) ISO-V	Nb 3.4	Fe 0.40 Hardness				
WELDING POSITIONS: ALL-WELD METAL ANA C 0.025 ALL WELD METAL PRC Heat Treatment	Mn 0.4 PERTIES (TYPICAL) RP0,2 (N/mm <sup>2</sup> )	Si 0.3 Rm (N/mm <sup>2</sup> )	Cr 21.0	Ni rem Impact E -20°C -4	Mo 9.0 nergy (J) ISO-V 0°C	Nb 3.4 -196°C	Fe 0.40 Hardness HRc / HV				

AW: as welded

## WELDING PARAMETERS / PACKING

	Welding Parameters	5	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 TEMPER	ATURE 150°C / 24hr					
GAS ACC. EN ISO	14175: M21					