

E NiCrO 625 HLS

CATEGORY SMAW Stick Electrodes

TYPE Nickel based high recovery electrode

APPLICATIONS NiCrO 625 HLS is developed for 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.

PROPERTIES Latest generation high recovery type (170%) guarantees optimum deposit rate and metallurgical quality and attractive welder appeal in the PA-PB position.
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 5.11: E NiCrMo 3
EN ISO	14172: E Ni 6625 (NiCr22Mo9Nb)
DIN: W.Nr.	2.4621
DIN	1736: EL-NiCr20Mo9Nb

SUITABLE FOR 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

WELDING POSITIONS:



Ni	C	Mo	Nb	Cr
Rem	0.6	8-11	2-4	19-30

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	450	760	30	75		60	

AW: as welded

WELDING PARAMETERS / PACKING

Welding Parameters			Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack	kg / 1000
2.5	350	60-90	2.5	15	
3.2	350	80-110	2.6	15.6	
4.0	350	100-150	2.8	16.8	
5.0	350	150-220	3.2	19.2	

REDRYING TEMPERATURE 320°C/2h