# Inconel 112 (E NiCro 625)

**CATEGORY SMAW Stick Electrodes** 

**TYPE** Latest generation clean quality (vacuum melted core wire) guarantees optimum metallurgical quality and

attractive welder appeal.

**APPLICATIONS** Nicro 625 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.

**PROPERTIES** 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.

A 5.11: E NiCrMo-3 CLASSIFICATION AWS

> EN ISO 14172: E Ni 6625

DIN: W.Nr. 2.4621

DIN 1736: EL-NiCr20Mo9Nb

**SUITABLE FOR** 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, N08002. 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, 2.4660

**APPROVALS** CE approved

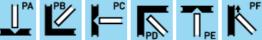
WELDING POSITIONS:















# WELD METAL ANALYSIS %

Ni+Co	С	Mn	Fe	S	Si	Cu	Cr	Nb+Ta	Мо	Р	Other
> 55.0	0.10	< 1.0	< 7.0	< 0.02	< 0.75	< 0.50	20.0-23.0	3.15+4.15	8.0-10.0	< 0.03	0.50

### **MECHANICAL PROPERTIES**

Heat	R <sub>P0,2</sub>	Rm	A5	Impact Energy (J) ISO-V		Hardness	
Treatment	(N/mm <sup>2</sup> )	(N/mm <sup>2</sup> )	(%)	20°C	-40°C	-196°C	HRc / HV
AW	> 450	> 760	> 30	> 75		> 45	

#### AW: as welded

## WELDING PARAMETERS / PACKING

	Welding Parameters	Packing		
D (mm)	Length (mm)	Current (A)	kg / can	kg / 6 pack
2.4	229	40-65	2.27	13.62
3.2	356	65-90	2.27	13.62
4.0	356	90-125	2.27	13.62

REDRYING TEMPERATURE

260°/2hr