

## SA Nicro 625

**CATEGORY** SAW Arc Submerged

**TYPE** Nickel - Chromium - Molybdenum alloy for SAW welding.

**APPLICATIONS** SA 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 or to stainless steels and for joining 6% molybdenum super austenitic steels.. SA Nicro 625 is most commonly used in the chemical processing industry, pollution control equipment, marine equipment, nuclear reactor components, pump shafts. Also used in the aerospace industry for thrust reverser assemblies, fuel nozzles, after-burners and combustion systems.

**PROPERTIES** SA Nicro 625 is a solid drawn wire to be used for the submerged arc process in combination with **FL 880** or **FL 839** flux.

**CLASSIFICATION**

AWS	A 5.14: ER NiCrMo-3
EN ISO	18274: SNi6625
DIN: W.Nr.	2.4831
DIN	1736: SG NiCr21Mo9Nb

**SUITABLE FOR** Nicro 625 is developed for welding and cladding nickel-based alloys such as alloy 625, 825 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., X10NiCrAlTi, 32-20H, 32-21, X8 Ni9, ASTM A 533 Gr1, 800H, Sanicro 28, 2545Mo, inconel 625, UNS : N08926, N08825, N06625, N08020. 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** TUV, CE approved

**WELDING POSITIONS:**



**ALL-WELD METAL ANALYSES % (TYPICAL)**

C	Mn	Si	Cr	Ni	Mo	Nb+Ta	Ti	Fe
<0.04	<0.5	<0.60	20.0-22.5	Rem	8.0-10.0	3.15-4.15	0.4	<0.7

**MECHANICAL PROPERTIES**

Flux type as welded	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc / HV
				20°C	-40°C	-196°C	
FL 880*	>440	>740	>30	>70		>50	
FL 839	>430	>700	>30	>70		>32	

\* maximum wire diameter 2,0 mm

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters			Travel speed (cm/min)
	Voltage (V)	Current (A)		
1,6	26-29	225-325		35-60
2,4	29-33	300-400		35-60
3,2	29-33	350-500		35-60
4,0	30-36	400-600		35-60

**REDRYING TEMPERATURE** not required