

SA Nicro 625 strip

CATEGORY ESWA Electroslag

TYPE Nickel Chromium Molybdenum based strip for cladding applications.

APPLICATIONS This strip is suitable for both electroslag (ESW) and subarc (SAW) process. Typical applications include cladding of vessels for the petrochemical, refinery and chemical industries

PROPERTIES Weld metal deposited by SA Nicro 625 has high strength and extreme corrosion resistance, including oxidation resistance and creep-rupture strength at elevated temperatures.

CLASSIFICATION AWS A 5.14: EQ NiCrMo-3
DIN: W.Nr. 2.4831

SUITABLE FOR SA Nicro 625 is mainly used for ESW and SAW cladding of carbon steel to obtain corrosion and creep resistant layers. Go to [FL 860 ESHC](#) suitable flux...

WELDING POSITIONS:



C	Mn	Si	Cr	Ni	Mo	Nb+Ta	Ti	Fe
<0.02	0.02	<0.02	22.2	Rem	8-10	3.65	0.162	<0,7

MECHANICAL PROPERTIES

Heat treatment	RP0,2 (N/mm2)	Rm (N/mm2)	A5 (%)	Impact energy (J) ISO-V			Hardness HRc / HV
				20C	-40°C	-196°C	
AW	>460	>750	>32	>110		>70	

WELDING PARAMETERS WITH FL 860 ESHC / PACKING

Welding Parameters			Packing	
thickness (mm)	width (mm)	Current (A) (DC+)	Coil ID (mm)	kg / Coil
0.5	30	450-650	600	25-50
0.5	60	900-1200	600	50-100
0.5	90	1350-1900	600	100-250
0.5	120	1750-2500	600	100-250

REDRYING TEMPERATURE not required