



# CEWELD AA NiCr 625B

|                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                          |                      |                    |                         |     |     |          |      |
|----------------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------------------------------------------|----------------------|--------------------|-------------------------|-----|-----|----------|------|
| TYPE                                               | Basic flux-cored nickel base welding wire for gas shielded arc welding.                                                                                                                                                                                                                                                                                                                                                                                                                                                            |                                          |                      |                    |                         |     |     |          |      |
| ANWENDUNGEN                                        | 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.                                                                                                                                                                                                                              |                                          |                      |                    |                         |     |     |          |      |
| EIGENSCHAFTEN                                      | Latest generation basic slag guarantees optimum metallurgical quality and attractive welder appeal. The weld 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.                                                                                                                                                                                                                                            |                                          |                      |                    |                         |     |     |          |      |
| KLASSIFIKATION                                     | AWS                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                | A 5.34: E NiCrMo3T1-4                    |                      |                    |                         |     |     |          |      |
|                                                    | EN ISO                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             | 12153-A: T Ni 6625 (NiCr22Mo9Nb) B M21 3 |                      |                    |                         |     |     |          |      |
|                                                    | F-nr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 43                                       |                      |                    |                         |     |     |          |      |
|                                                    | FM                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                 | 6                                        |                      |                    |                         |     |     |          |      |
| GEEIGNET FÜR                                       | <b>Ni 6625 / NiCr22Mo9Nb / 2.4831</b><br>1.4547 - 1.4876 - 1.4958 - 2.4816 - 2.4856 - 2.4858 - 1.5656 - 1.4529 - 1.4539 - 2.4660<br>X1CrNiMoCuN20-18-7 - X10NiCrAlTi32-20 - X5NiCrAlTi31-20 - NiCr15Fe - NiCr22Mo9Nb - NiCr21Mo - X1NiCrMoCuN25 20 6 - X1NiCrMoCuN25 20 5 - NiCr21Mo - 8XNi9<br>UNS: S31254 - N08800 - N08810 - N06600 - N06625 - N08825 - N08926 - N08020<br>ASTM A 553 Gr.1, Alloy 600, Alloy 600 L, Alloy 625, Alloy 800 / 800H, Alloy 825<br>Alloy 254SMO - Sanicro 28 - 6Mo                                   |                                          |                      |                    |                         |     |     |          |      |
| ZULASSUNGEN                                        |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                          |                      |                    |                         |     |     |          |      |
| SCHWEISSPOSITIONEN                                 | <div>     </div> |                                          |                      |                    |                         |     |     |          |      |
| TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%) | C                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                  | Si                                       | Mn                   | Cr                 | Ni                      | Mo  | Nb  | Fe       | S    |
|                                                    | 0.03                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                               | 0.35                                     | 0.45                 | 21.5               | 60.5                    | 9.5 | 3.4 | 4        | 0.01 |
| MECHANISCHE GÜTEWERTE                              | Heat Treatment                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                     | R <sub>P0,2</sub> (MPa)                  | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |     |     | Hardness |      |
|                                                    |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                    |                                          |                      |                    | -196°C                  |     |     |          |      |
|                                                    | As Welded                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                          | 500                                      | 780                  | 40                 | 60                      |     |     | HRc      |      |
| RÜCKTROCKNUNG                                      | 140°C / 24 hr                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                      |                                          |                      |                    |                         |     |     |          |      |
| GAS ACC. EN ISO 14175                              | M21                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                          |                      |                    |                         |     |     |          |      |