



CEWELD Alloy 825 Tig

TYPE Solid Nickel based welding wire for gas tungsten arc welding

APPLICATIONS The excellent corrosion-resistant properties of CEWELD Alloy 825 make the alloy a suitable choice for a variety of difficult applications. Uses include fabricated equipment found in chemical and petro- chemical processing, pulp and paper manufacturing, flue gas desulphurization systems and metal pickling operations.

PROPERTIES Excelent weldability with fully austenitic weld metal with high resistance against stress corrosion cracking and pitting in media containing chloride ions. Good corrosion resistance against reducing acids due to the combination of Ni, Mo and Cu. Sufficient resistance against oxidizing acids. The weld metal is corrosion resistant in sea water. Good resistance to nitric acid.

CLASSIFICATION

AWS	A 5.14: ERNiFeCr-1
EN ISO	18274: S Ni 8065(NiFe30Cr21Mo3)
W.Nr.	2.4858
F-nr	43
FM	6

SUITABLE FOR G-X7NiCrMoCuNb25-20, X1NiCrMoCuN25-20-6, X1NiCrMoCuN25-20-5, NiCr21Mo, X1NiCrMoCu31-27-4, N08926, N08904, N08028, N08825 ALLOY 825
1.4500, 1.4529, 1.4539 (904L), 2.4858, 1.4563, 1.4465, 1.4577 (310Mo), 1.4133, 1.4500, 1.4503, 1.4505, 1.4506, 1.4531, 1.4536, 1.4585, 1.4586

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Cu
0.04	4	0.8	21	42	2	1	30	2

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V	Hardness
				RT	
As Welded	425	630	30	100	HRc

REDRYING Not required

GAS ACC. EN ISO 14175 I1



CEWELD Alloy 825 Tig

ALLOY 825 TIG 1,2 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663419613

ALLOY 825 TIG 1,6 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663419644

ALLOY 825 TIG 2,0 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663419637

ALLOY 825 TIG 2,4 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663419620

ALLOY 825 TIG 2,4 X 914MM

Packaging	KG/unit	EanCode
Tube	4,54	8720663419071

ALLOY 825 TIG 3,2 X
1000MM

Packaging	KG/unit	EanCode
Tube	5	8720663419668