

NICROMIG 625

MIG/MAG Wires [GMAW]

Nickel alloys

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 18274-A : S Ni 6625 DIN 1736 : SG NiCr21 Mo 9 Nb AWS A-5.14 : ER NiCrMo-3	CE, TUV	Power generation industry Hardfacing and repairing Constructions & Engineering Petrochemical and chemical industry

Проволока применяется для сварки сплавов никеля и соединения аустенитных и ферритных сталей, а также для разносортных соединений.

Base material

DIN	W.Nr.	DIN	W.Nr.	DIN	W.Nr.
X2NiCrAlTi3220	1.4558	NiCr20Ti	2.4951	X12Ni5	1.5680
NiCr20TiAl	2.4631	NiCr15Fe	2.4618	GX10Ni5	1.5681
NiCr23Mo16Al	2.4605	LC-NiCu15Fe	2.4817	X3CrNiN1810	1.6907
NiCr22Mo6Cu	2.4618	NiCr23Fe	2.4851	X3CrNiMoN184	1.6967
NiCr22Mo7Cu	2.4619	NiCr22Mo9Nb	2.4856	X10NiCrAlTi3220	1.4876
NiCr20Ti	2.4630	NiCr21Mo	2.4858	X8NiCrAlTi3221	1.4959
NiCr21Mo6Cu	2.4641	X6CrNi2520	1.4951	Alloy 800	
NiCr20CuMo	2.4660	X8Ni9	1.5662	Alloy 800HT	

Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	Nb	Fe
0,03	0,25	0,20	22,0	reszta	9,0	3,6	<1,5

Typical mechanical properties

Yield strength Re [N/mm ²]	>420
Tensile strength Rm [N/mm ²]	>760
Elongation A5 [%]	>30
Impact energy Kv [J]	>60J (-40°C) /

Welding parameters and packing

∅	Ток сварки [A]	Вес пачки [кг]
0,8	80-130	15,0
1,0	120-190	15,0
1,2	180-250	15,0

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