

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

- Wire used for welding nickel alloys and joining austenitic and ferritic steels and for dissimilar connections.
- Very high resistance to various types of corrosion.
- Can be used to join steels with a high molybdenum content.
- Resistant to thermal shocks, hot cracks, stress corrosion cracking, pitting corrosion (PREN approx. 52).

Application

For dedicated materials, dissimilar connections, plating. Heat shields, kiln fittings (scrubbers), gas turbine engine hoses, combustion chamber linings, chemical plant fittings, seawater specialty applications. In the aerospace industry (exhaust devices, fuel lines, heat exchanger housings). Large number of applications in the nuclear industry (very low cobalt content). In general industry (tanks, heat exchangers, valves and fluid distribution systems, pipes). Waste disposal (reheaters), pulp and paper industry. Various fasteners, compensators, exhaust systems.

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	rest	9,0	3,6	<1,5

Typical mechanical properties

Yield strength Re [N/mm²]	>420
Tensile strength Rm [N/mm²]	>760
Elongation A5 [%]	>30
Impact energy Kv [J]	>60J (-40°C) /
Shielding gases acc. to EN ISO 14175	I1 - Ar / I3 - Ar + >0-95% He /

Welding parameters and packing

∅	Welding current [A]	Voltage [V]	Weight of packet [kg]
0,8	80-130		15,0
1,0	120-190	16-29	15,0

1,2	180-250	18-29	15,0
1,6	250-320	22-32	15,0

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