TOKO®

TOKO Technology(Wuxi) Co.,Ltd
Email: global@tokoc.com
Web: http://www.tokoc.com

CERTIFICATE OF QUALITY

NiCro 625

CATEGORY: GMAW-GTAW Solid wires

TYPE: Solid nickel base welding wire for gas shielded arc welding.

APPLICATIONS:
NiCro 625 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.. NiCro 625 is most commonly used in the chemical processing industry, pollution control equipment, marine equipment, nuclear reactor components, pump shafts. Also used in the aerospace industry for thrust reverser assemblies, fuel nozzles, after-burners and combustion systems.

PROPERTIES:
Nicro 625 is a solid drawn wire that is cleaned in a very special way to obtain cleaner and higher quality welds, especially when used for the Hotwire Tig process intermediate cleaning between the layers can be skipped and results in a bright seam with excellent ductility. The cast and helix of this wire are kept above the EN standards to offer excellent wire feeding and a wire that comes straight out of the torch.

CLASSIFICATION:
AWS A 5.14: ER NiCrMo-3 | EN ISO 18274: S Ni 6625 (NiCr22Mo9Nb)
DIN: W.Nr. 2.4831 | DIN 1736: SG NiCr21Mo9Nb

SUITABLE FOR:
Nicro 625 is developed for welding and cladding nickel-based alloys such as alloy 625, 825 or similar materials. This alloy can also be used for welding dissimilar nickel-based alloys to each other, to alloyed steels, to stainless steels and for joining 9% Nickel steels., X10NiCrAlTi, 32-20H, 32-21, X8 Ni9, ASTM A 533 Gr1, 800H, Sanicro 28, 254SMo, inconel 625, UNS : N08926, N08825, N06625, N08020. DIN : X8Ni9, X1NiCrMoCuN25 20 6, X1NiCrMoCuN25 20 5, NiCr21Mo, NiCr22Mo9Nb W.Nr:: 1.4876, 1.5656, 1.4529, 2.4858, 2.4856, 1.4539,1.4547, 2.4660

WELDING POSITIONS:

TYPICAL WELD DEPOSIT WEIGHT % :

Dia (mm)	Chemical Composition (%)								
	C	Si	Mn	Cr	Mo	Nb+Ta	Ti	Fe	Ni
	<0.02	<0.20	0.02	22.19	8~10.0	3.65	0.162	<0.7	Rem
	Melting metal mechanical performance								
1.2	RP0,2 (N/mm²)	Rm (N/mm²)	A5 %	Impact Energy (J) ISO-V +20°C -40°C -196°C			Hardness HRc / HV		
	>460	>750	>32	>110		>70			

Quality Control Stamp: Date: March-17,2019