

CERTIFICATE OF QUALITY

AWS A5.11 NiCrMo-3

APPLICATIONS:

NiCr625 is a basic electrode, core wire alloyed for welding the nickel-based alloy 625 and 825 as well as CrNiMo- steel with high molybdenum content (e.g: “6%Mo” steels). It is also recommended for high temperature and creep resisting steels, heat resisting and cryogenic materials, dissimilar joints, and low-alloyed problem steels.

CLASSIFICATION:

AWS A 5.11: ENiCrMo-3 | EN ISO 14172: E Ni 6625 (NiCr22Mo9Nb)

DIN: W.No. 2.4831 | DIN 1736: SG NiCr21Mo9Nb


SUITABLE FOR:

Suitable in pressure vessel fabrication for -196°C to +550°C, otherwise up to the scaling resistance temperature of +1200°C (S-free atmosphere). Due to the weld metal embrittlement between 600-850°C, this temperature range should be avoided. Highly resistant to hot cracking. Furthermore C-diffusion at high temperature or during heat treatment of dissimilar joints is largely reduced. Extremely resistant to stress corrosion cracking and pitting (PREn 52). Thermal shock resistant, fully austenitic, low coefficient of thermal expansion between C-steel and austenitic CrNi (Mo) Steel. 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, 2.4831

WELDING POSITIONS:



TYPICAL WELD DEPOSIT WEIGHT % :

Diameter (MM)	Chemical Composition (%)								
	C	Si	Mn	Cr	Mo	Nb+Ta	Ti	Fe	Ni
	0.025	0.35	0.02	22.20	8.6	3.65	0.162	<0.7	Rem
3.2MM	Melting Metal Mechanical Performance								
	Yield Strength Rp0,2 (N/mm2)	Tensile Strength Rm (N/mm2)	Elongation A5 %	Impact +20°C	ISO-VKV J -196°C				
	530MPa (≥420)	800MPa (≥760)	37 (≥27)	90	45(≥32)				

Quality Control Stamp:

Date: May-05,2019