



CEWELD AA NiCro 625

TYPE	Rutile flux-cored nickel based welding wire for gas shielded arc welding.								
ANWENDUNGEN	AA Nicro 625 is developed for welding and cladding nickel-based alloys such as Inconel 625 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.								
EIGENSCHAFTEN	Latest generation rutile flux cored wire, guarantees optimum metallurgical quality, economic positional welding and attractive welder appeal.Very good resistance against pitting corrosion and crevice corrosion.Very good against acid, neutral or alkaline media, with or without chlorides.Very good resistance at high temperatures, especially against oxidation.								
KLASSIFIKATION	AWS	A 5.34: E NiCrMo3T1-4							
	EN ISO	12153-A: T Ni 6625 (NiCr22Mo9Nb) P M21 2							
	W.Nr.	2.4831							
	F-nr	43							
	FM	6							
GEEIGNET FÜR	Ni 6625 / NiCr22Mo9Nb / 2.4831 W.Nr: 1.4529, 1.4539, 1.4547, 1.4876, 1.4958, 1.5656, 2.4660, 2.4816, 2.4856, 2.4858, X1CrNiMoCuN20-18-7 - X10NiCrAlTi32-20 - X5NiCrAlTi31-20 - NiCr15Fe - NiCr22Mo9Nb - NiCr21Mo - X1NiCrMoCuN25 20 6 - X1NiCrMoCuN25 20 5 - NiCr21Mo - 8XNi9 ASTM: A 533 Gr1 UNS: S31254 - N08800 - N08810 - N06600 - N06625 - N08825 - N08926 - N08020 Alloy 254SMO - Alloy 800 - Alloy 800H - Alloy 600 - Alloy 625 - Alloy 825 - Sanicro 28 - 6Mo								
ZULASSUNGEN									
SCHWEISSPOSITIONEN									
TYPISCHE CHEMISCHE ANALYSE DES SCHWEISSMETALLS (%)	C	Si	Mn	Cr	Ni	Mo	Nb	Fe	S
	0.03	0.35	0.45	21.5	60.9	9.5	3.5	4	0.01
MECHANISCHE GÜTEWERTE	Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness	
	As Welded	500	780	40	0°C	-100°C	-196°C	HRc	
RÜCKTROCKNUNG	140°C / 24 hr								
GAS ACC. EN ISO 14175	M21								



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AA NICRO 625 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663418821