



# CEWELD E NiCr 625 HLS

**TYPE** Nickel based high recovery electrode. (Type 6625, ENiCrMo-3)

**APPLICATIONS** **CEWELD® E NiCr 625 HLS** is developed for 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, to stainless steels and for joining 9% Nickel steels.

**PROPERTIES** **CEWELD® E NiCr 625 HLS** have a 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. High recovery of 140%

**CLASSIFICATION**

|        |                                |
|--------|--------------------------------|
| AWS    | A 5.11: E NiCrMo-3             |
| EN ISO | 14172: E Ni 6625 (NiCr22Mo9Nb) |
| W.Nr.  | 2.4621                         |
| F-nr   | 43                             |
| FM     | 6                              |

**SUITABLE FOR** **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, B443, B444, B446  
**UNS:** S31254 - N08800 - N08810 - N06600 - N06625 - N08825 - N08926 - N08020  
 Alloy 254 SMO - Alloy 800 - Alloy 800H - Alloy 600 - Alloy 625 - Alloy 825 - Sanicro 28

**APPROVALS**

**WELDING POSITIONS**



**TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)**

| C    | Si  | Mn  | Cr | Ni | Mo | Fe | Nb+Ta | Nb  |
|------|-----|-----|----|----|----|----|-------|-----|
| 0.08 | 0.6 | 0.7 | 22 | 60 | 9  | 5  | 4     | 3.8 |

**MECHANICAL PROPERTIES**

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
|                |                         |                      |                    | RT                      | -196°C |          |
| As Welded      | 455                     | 795                  | 37                 | 78                      | 60     | HRc      |

**REDRYING** 300°C / 2 hr

**GAS ACC.** EN ISO 14175



# CEWELD E NiCro 625 HLS

E Nicro 625 HLS 2,5 X  
350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,27    | 8720663418746 |

E Nicro 625 HLS 3,2 X  
350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,27    | 8720663418753 |

E Nicro 625 HLS 4,0 X  
350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,27    | 8720663418760 |