



# CEWELD SA Nicro 625

**TYPE** Nickel - Chromium - Molybdenum alloy for SAW welding.

**APPLICATIONS** SA 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.. SA 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** SA Nicro 625 is a solid drawn wire to be used for the submerged arc process in combination with our fused flux FL 880 or agglomerated flux FL 838 or FL 839.

**CLASSIFICATION**

AWS	A 5.14: ERNiCrMo-3
EN ISO	18274: S Ni 6625 (NiCr22Mo9Nb)
W.Nr.	2.4831
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  
**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 THE FILLER METAL (%)**

C	Si	Mn	Cr	Ni	Mo	Nb	Ti	Fe
0.04	0.5	0.5	22	68	9	3.9	0.2	3

**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	470	770	35	80	50	HRC

**REDRYING** Not required

**GAS ACC. EN ISO 14175**



# CEWELD SA Nicro 625

SA NICRO 625 1,6MM

Packaging	KG/unit	EanCode
K-415	25	8720663412034

SA NICRO 625 2,4MM

Packaging	KG/unit	EanCode
K-415	25	8720663412041

SA NICRO 625 3,2MM

Packaging	KG/unit	EanCode
K-415	25	8720663412058