

SR-625

Conformances

AWS A5.11/ ASME SFA5.11 ENiCrMo-3
 JIS Z3224 DNiCrMo-3
 EN ISO 14172 Ni 6625 (NiCr22Mo9Nb)
 ABS AWS A5.11 ERNiCrMo-3

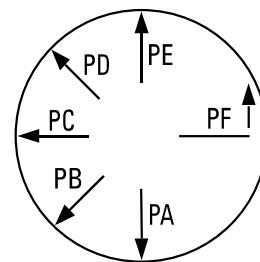
Applications

- Inconel 601 + 625, steel and Nickel alloys Hardfacing of steel
- 9% Nickel steel
- LNG storage tank manufactures and desulfurizations
- Heat exchanger Building of chemical carrier

Features

- Good corrosion resistance to Crevice and Pitting, SCC
- Good Tensile Strength at High Temperature
- Good Impact value at Cryogenic temperature

Welding Position



Current

DC +, AC

Diameter / Packaging

Diameter mm (in)	Length mm(in)	
	300 (12)	350 (14)
2.6 (3/32)	✓	
3.2 (1/8)		✓
4.0 (5/32)		✓
5.0 (3/16)		✓

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Nb+Ta	Fe
0.06	0.4	0.1	0.001	0.004	21.7	63.4	9.3	3.32	1.52

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft-lbs)
-	780 (113,000)	36.0	-196 (-321)	45 (33)

Typical Welding Parameters

Diameter	Approx. Current (Amps)			
	2.6mm (3/32) DC +	3.2mm (1/8) DC +	4.0mm (5/32) DC +	5.0mm (3/16) DC +
F	60~90	70~110	110~140	120~150
V-up/OH	60~90	70~110	100~130	110~140