

SW-625

Conformances

AWS A5.34/ ASME SFA5.34 ENiCrMo3T1-4

EN ISO 12153 T Ni 6625 P M 2

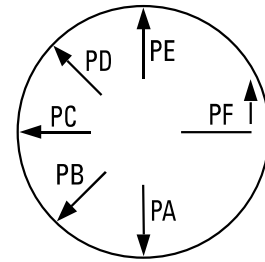
Applications

- Joining nickel-chromium-molybdenum alloys cladding steel with nickel-chromium-molybdenum weld metal LNG storage
- LNG storage tank manufactures
- Desulfurizations
- Heat exchangers

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 +

Shielding Gas

Ar + 20% CO₂

Diameter / Packaging

Diameter	Spool
mm (in)	12.5kg (27.6lbs)
1.2 (0.045)	✓

Typical Chemical Composition of All-Weld Metal (%)

	C	Si	Mn	P	S	Cr	Ni	Mo	Fe	Nb+Ta
Ar + 20% CO ₂	0.07	0.35	0.29	0.003	0.002	20.7	61.8	9.1	3.5	3.4

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)
As-weld	-	810 (117,000)	36.0	-196 (-321)	60 (44)
PWHT(620°C*8Hr)	-	825 (120,000)	36.4	-196 (-321)	55 (41)

Typical Welding Parameters

Approx. Current (Amps)	
Diameter	1.2mm (0.045) DC +
F&HF	180~220
V-up/OH	120~170