CARBOWELD 625

CARBO◆WELD®

Material No.: 2.4621
EN ISO 14172: E Ni 6625 (NiCr22Mo9Nb)
AWS A 5.11: ~E NiCrMo-3

Approvals

Typical application and characteristics

CARBOWELD 625 is nickel base electrode with a recovery of 140% and excellent weldability on AC even at low voltages. Previously suitable for claddings, where the characteristics of the deposits alloy are required. The austenitic deposit is insensitive to hot-cracking and free of embrittle-ment at high as well as at low temperatures, non-scaling up to 1100° C, and cold tough down to –196°C. No diffusion of carbon into the weld metal at high temperatures. Used for service-temperatures of more than 300°C in Chemical Industry, Petrochemical Industry, glassworks, civil engineering, repairing and main-tenance workshops.

Weld metal analysis (typical)

wt.-%	C 0,04	Si 1,0	Mn 0,6	Mo 9,0	Cr 22,0	Ni Basis	Nb 3,5	Fe <6,0			

Base materials

1.4558	X2NiCrAlTi32-20	2.4641	NiCr21Mo6Cu	2.4856	NiCr22Mo9Nb	1.6967	X3CrNiMoN18-4
2.4631	NiCr 20 TiAl	2.4660	NiCr20CuMo	2.4858	NiCr21Mo	1.4876	X10NiCrAlTi32-20
2.4605	NiCr23Mo16Al	2.4951	NiCr20Ti	1.5662	X8Ni9		Alloy 800
2.4618	NiCr22Mo6Cu	2.4816	NiCr15Fe	1.5680	X12Ni5	1.4958	X5NiCrAlTi31 20
2.4619	NiCr22Mo7Cu	2.4817	LC-NiCu15Fe	1.5681	GX10Ni5		Alloy 800H
2.4630	NiCr20Ti	2.4851	NiCr23Fe	1.6907	X3CrNiN18-10		

Operating data

Current:	=+
Welding positions:	PA, PB, PC, PD, PE, PF
Rebaking:	2 h, 300°C +/- 10°C (if nacessary)

Dia./Length	Amperage (A)	Pcs. / packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	65 - 100	143	874	18,3	4,0	16,0
3,2 x 350	95 - 130	85	559	35,8	5,0	20,0
4,0 x 450	120 - 170	56	380	52,5	5,0	20,0
5,0 x 450	170 - 240	33	133	179,8	6,0	24,0