

Standards	Material No.	2.4831
	AWS SFA-5.11	E-NiCrMo 3
	DIN 1736	NiCr 20 Mo 9 Nb

Characteristics CARBO F-Ni 625 is nickel base tubular wire, suitable for joining and cladding stainless, heat resistant and cold tenacious steels as well as welding dissimilar materials for example low alloyed steels with Ni-base or Cu-base alloys

The austenitic deposit is insensitive to hot-cracking and free of embrittlement 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.

Applications Used for service-temperatures of more than 300° C in Chemical Industry, Petrochemical Industry, glassworks, civil engineering, repairing and maintenance workshops.

Mechanical properties of all-weld metal (typical values)	Tensile strength R _m N/mm ²	Yield strength R _{p0,2} N/mm ²	Elongation A ₅ %	Impact energy ISO-V (-196°C)
	750	500	35	40 J

Weld metal analysis (typical, wt. %)	C	Si	Mn	Cr	Ni	Mo	Nb	Fe
	0,04	0,8	0,6	22	Basis	9	3,5	< 6

Gas types EN 439 I1, Argon

Current = +

Current intensity	DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
	1,2	3/64	19 - 22	120 - 220	G
	1,6	1/16	20 - 26	160 - 260	G
	2,0	5/64	22 - 27	220 - 280	G
	2,4	3/32	24 - 28	260 - 340	G S
	2,8	7/64	25 - 29	300 - 400	S
	3,2	1 / 8	26 - 30	320 - 460	S

Delivering form

O = Flux cored wire self shielding
G = Flux cored wire for shielded arc welding
S = Flux cored wire for submerged arc welding

Coils, weight B/BS 300 = 15 kg B 450 = 30 kg pay off pack = 150 / 300 kg

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.