

Standards :

**Chemical Composition of Weld Metal-
% (Typical) :**

TS EN ISO 14172 : E-Ni 6625(NiCr22Mo9Nb)
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AWS A5.11 : ENiCrMo-3

C	Mn	Si	Mo	Ni	Fe	Cr	Ti	Nb
0.04	0.4	0.7	9.0	kalan	5.0	21.0	+	3.5

Mechanical Properties :

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength		Elongation (L ₀ =5d ₀)(%)
		(ISO-V/+20°C)	(ISO-V/-196°C)	
min. 420	min. 760	min. 60 J	min. 35 J	min. 30

Typical Base Material Grades :

- | | |
|---|-------------------------------------|
| -1.4529 X2 NiCrMoCu 25 20 6 | -2.4951 NiCr 20 Ti (ASTM 75) |
| -1.4583 X10 NiCrMoNb 18 12 | -2.4952 NiCr 20 TiAl (ASTM 80A) |
| -1.4876 X10 NiCrAlTi 32 20 (incoloy800) | -ASTM B443, B444, B446 (UNS N06625) |
| -1.5662 X8 Ni 9 (ASTM 9Ni) | |
| -2.4816 NiCr 15 Fe (inconel 600) | |
| -2.4856 NiCr 22 Mo 9 Nb (inconel 625) | |
| -2.4858 NiCr 21 Mo (inconel 825) | |

Features and Applications :

- * High Molybdenum Nickel-base alloy electrode for creep-resistant steels, heat resisting steels, heat resisting and Cryogenic materials, dissimilar joints and high strength problem steels.
- * Especially designed for Inconel 625 and Incoloy 825. * Re-drying cond. : 250-300 °C / 2 h.

Welding Positions :



Current Type :

D.C.(+)

Operating Data :

Diameter x Length (mm)	Diameter x Length (inch)	Welding Current (A)	Weight g /100 pcs
2.50 x 250	3/32 x 10"	60 - 80	1530
3.20 x 300	1/8 x 12"	70 - 100	3225
4.00 x 350	5/32 x 14"	90 - 130	5200

Approvals :

CE, GOST-R, SEPRO