

EZ - MIG 625

CLASSIFICATION

HRN EN ISO 18274	AWS / ASME SFA-5.9	W. Nr.
S Ni 6625 (NiCr22Mo9Nb)	ERNiCrMo-3	2.4831

DESCRIPTION AND APPLICATION

Austenitic Ni-base solid wire for GMAW of special and high quality corrosion resistant steels and nickel alloys. It's used for welding and cladding of identical and dissimilar steels, for example – CrMn steels, creep resistant CrMo steels and Ni steels. It can be used for great service temperature range: from extremely low temperature (-196°C) to very high (about 1000 °C).

Steel grade	DIN (W. Nr.)
High alloy stainless steels	NiCr22Mo9Nb - Alloy 625 - UNS N06625 (2.4856) X1NiCrMoCuN 25-20-7- Alloy 926 - UNS N08925 (1.4529) 16Mo3 - ASTM A672 (1.5415) P235TR1 - ASTM A53 (1.0254)

MECHANICAL PROPERTIES OF THE ALL-WELD METAL

R _{p0.2} N/mm ²	R _m N/mm ²	A ₅ %	KV (+20°C) J	KV (-196°C) J
> 450	> 760	> 30	≥ 80	≥ 60

APPROXIMATE CHEMICAL COMPOSITION OF THE WIRE

C	Mn	Si	Cr	Ni	Mo	Nb
% ≤ 0,03	0,2	0,25	22,0	bal.	9,0	3,5

SHIELDING GAS

I1 (Ar); M12 (Ar +30% He+0,5% CO₂)

PACKAGING

Wire diameter mm	Winding
0,8; 1,0; 1,2	precision-wound (S-S)

15 kg - wire spool

