



# CEWELD E NiCro 625 HLS

TYPE Nickel based high recovery electrode

APPLICATIONS CEWELD® E NiCro 625 HLS is developed for cladding Nickel-based alloys such as Alloy 625 or similar materials. This alloy can also be used for welding dissimilar nickel-based alloys to each other, to alloyed steels, to stainless steels and for joining 9% Nickel steels.

PROPRIÉTÉS Latest generation high recovery type (170%) guarantees optimum deposit rate and metallurgical quality and attractive welder appeal in the PA-PB position. Very good resistance against pitting corrosion and crevice corrosion. Very good against acid, neutral or alkaline media, with or without chlorides. Very good resistance at high temperatures, especially against oxidation.

CLASSIFICATION

|        |                                |
|--------|--------------------------------|
| AWS    | A 5.11: E NiCrMo-3             |
| EN ISO | 14172: E Ni 6625 (NiCr22Mo9Nb) |
| W.Nr.  | 2.4831 / 2.4621                |
| F-nr   | 43                             |
| FM     | 6                              |

CONVIENT POUR **Ni 6625 / NiCr22Mo9Nb / 2.4831**  
**W.Nr:** 1.4529, 1.4539, 1.4547, 1.4876, 1.4958, 1.5656, 2.4660, 2.4816, 2.4856, 2.4858,

X1CrNiMoCuN20-18-7 - X10NiCrAlTi32-20 - X5NiCrAlTi31-20 - NiCr15Fe - NiCr22Mo9Nb - NiCr21Mo - X1NiCrMoCuN25 20 6 - X1NiCrMoCuN25 20 5 - NiCr21Mo - 8XNi9

**ASTM:** A 533 Gr1, B443, B444, B446

**UNS:** S31254 - N08800 - N08810 - N06600 - N06625 - N08825 - N08926 - N08020

Alloy 254SMO - Alloy 800 - Alloy 800H - Alloy 600 - Alloy 625 - Alloy 825 - Sanicro 28 - 6Mo

AGRÉMENTS

POSITIONS DE SOUDAGE



ANALYSE CHIMIQUE  
TYPIQUE DU MÉTAL DE  
SOUDURE (%)

| C    | Si  | Mn  | Cr | Ni | Mo | Fe | Nb+Ta | Nb  |
|------|-----|-----|----|----|----|----|-------|-----|
| 0.08 | 0.6 | 0.7 | 22 | 60 | 9  | 5  | 4     | 3.8 |

PROPRIÉTÉS MÉCANIQUES

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Impact Energy (J) ISO-V |        | Hardness |
|----------------|-------------------------|----------------------|--------------------|-------------------------|--------|----------|
|                |                         |                      |                    | RT                      | -196°C |          |
| As Welded      | 455                     | 795                  | 37                 | 78                      | 60     | HRC      |

ETUVAGE 300°C / 2 hr

GAS ACC. EN ISO 14175



# CEWELD E NiCro 625 HLS

E Nicro 625 HLS 2,5 X  
350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,27    | 8720663418746 |

E Nicro 625 HLS 3,2 X  
350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,27    | 8720663418753 |

E Nicro 625 HLS 4,0 X  
350MM

| Packaging | KG/unit | EanCode       |
|-----------|---------|---------------|
| Can       | 2,27    | 8720663418760 |