

Standards

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

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

C	Mn	Si	Mo	Ni	Fe	Cr	Ti	Nb
0.04	0.4	0.7	9.0	rest	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
- 1.4583 X10 NiCrMoNb 1812
- 1.4876 X10 NiCrAlTi 32 20 (Incoloy800)
- 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)
- 2.4951 NiCr20Ti (ASTM 75)
- 2.4952 NiCr 20 TLN (ASTM 80A)
- ASTM 8443, 8444, 8446 (UNS N06625)

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°C-300°C / 2h

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Welding Current (A)	Weight g / 100 pcs
3010101986	2.50 x 250	3/32 x 10"	60 - 80	1600
3010101991	3.20 x 300	1/8 x 12"	70 - 100	3220
3010101996	4.00 x 350	5/32 x 14"	90 - 130	5460

Approvals: SEPRO