

KW-A625

For nickel alloy (Inconel 625)

Classifications

EN ISO 14172:2004	: E Ni 6625
AWS A5.11-05	: ENiCrMo-3
JIS Z 3224	: DNiCrMo-3
KS D 7021	: DNiCrMo-3

Approvals

DNV	: NV 1.5 Ni, NV 3.5 Ni, NV 5Ni and 9 Ni. Test temperature -196°C
Other	: CE

Description

- Covering is lime titania type for welding of Inconel 625, Incoloy 825 and other molybdenum containing stainless steels
- The weld metal has high strength at room and elevated temperatures and has exceptional corrosion resistance, including resistance to pitting, crevice corrosion, etc
- The electrodes provide excellent operability for groove and fillet welding in the down hand position
- Easy slag removal, low spatter generation and stable arc characteristics
- Redry the electrode at 250 - 350 °C for 30 – 60 minutes prior to use

Welding positions



Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Fe	Ni	Cr	Mo	Nb + Ta
0.03	0.22	0.54	0.008	0.004	1.64	Rem.	21.9	8.6	3.8

Typical mechanical properties of all-weld metal

	Yield Strength (0.2%OS)	Tensile Strength	Elongation	Remarks
	(MPa)	(MPa)	(%)	
AWS A5.11		Min. 760	Min. 30	
EN ISO 14172	Min. 420	Min. 760	Min. 27	
Example	520	770	40	AW

*AW: As-welded

Sizes available and recommended currents (DC +)

Diameter	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Amperage	F	60-90	90-120	140-180	170-210
	V . OH	60-90	70-100	120-160	130-170