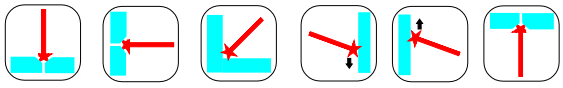
625 FCW-PW

EN ISO 12153: T Ni6625 P M21 2/ T Z Ni 6625 P C1 2
AWS A5.34/SFA-5.34: ENiCrMo3T1-4 / ENiGT1-1

DESCRIPTION

Nickel alloyed flux cored wire for welding high nickel alloyed steel such as Inconel 625, 825 and other similar alloys. Good resistance to various types of corrosion. For welding dissimilar nickel steels to each other or to other alloyed and stainless steels as well as to steels exposed to low temperatures down to -196°C. Designed for welding in all positions without risk of porosity. Resistant to scaling up to 1100°C.

WELDING POSITIONS	CURRENT	GAS
	DC+	M21, C1

BASE MATERIAL

625, 825, 25-6Mo, 1.4547, 1.4529, 1.4562, 1.4563, 1.5662, 2.4856, 2.4858

MECHANICAL PROPERTIES

Rm (Mpa)	***Rp 0,2 (Mpa)***	***A5 (%)***	***KV(j)***
750	475	42	-196°C: 72 +20°C: 83

CHEMICAL ANALYSIS(%)

C	Mn	Si	Cr	Mo	Nb	Fe	Ni
0,02	0,03	0,5	20,7	8,5	3,3	<1,0	Rest

PACKAGING & WELDING PARAMETERS

Dimension (mm)	1,2	1,2	
Voltage (V)	24-32 *(PF)*	24-32 *(PA, PB)*	
Amperage(A)	160-180 *(PF)*	200-220 *(PA, PB)*	
Stick out (mm)	15-20 *(PF)*	15-20 *(PA, PB)*	
Gas flow (l/min)	15-18 *(PF)*	15-18 *(PA, PB)*	
Wire feeding (m/min)	7-9,5 *(PF)*	10-11 *(PA, PB)*	

EQUIVALENT CONSUMABLES

MMA	Meltolit 625 XE /625 XHE
MIG	Meltolit 625 XM
TIG	Meltolit 625 XT
FCW	Meltolit 625 FCW