

GETIG 625

IDENTIFICATION: Getig 625 ERNiCrMo3

CLASSIFICATION: AWS/SFA-5.14: ERNiCrMo3, BS 2901-90 NA43

CHARACTERISTICS:

Solid nickel-base wire to match "625" type alloys with widespread applications. The wire gives a strong tough corrosion and heat resistant deposit. The deposited welds are of X-Ray quality. Also suitable for welding Alloy 825 and for dissimilar joint welding involving Inconel alloy 625 and Incoloy 825 alloys, carbon steel low alloy steel and stainless steel.

TYPICAL USES:

- Use for general purpose welding high nickel alloys for furnace parts for welding 6 % Mo super-austenitic stainless steels.
- Use for cladding overlays, pumps, valves joining faces in off-shore and marine environments.
- Suitable for welding 9 % nickel steels for cryogenic applications.

CORROSION RESISTANCE:

Very good resistance to general and intergranular corrosion. Maximum resistance to pitting corrosion crevice corrosion and stress corrosion cracking in chloride bearing environments.

SCALING TEMPERATURE: The weld metal is resistant to oxidation in air upto 1150oC.

WELDING CURRENT: DC(-)

SHIELDING GAS: 99.99% Agron 6-12 l/mn.

SIZES: 1.6 mm, 2.0 mm, 2.4 / 2.5 mm, 3.15/3.20 mm,

PACKING DATA:

SIZE (mm)	LENGTH (mm)	PACKING/BOX (KG)
1.6	1000/500	5 Kg
2.00	1000/500	5 Kg
2.50	1000/500	5 Kg
3.15/3.20	1000/500	5 Kg

COMPOSITION OF THE WIRE (RANGE) %

C	Mn	Si	Cr	Nb
0.05 max	0.50 max	0.50 max	20-23	3.15-4.15
Mo	S	P	Cu	Ti
8-10	0.015 max	0.015 max	0.50 max	0.40 max
Fe	Ni	Al		
3.0 max	60 min	0.40 max		

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	ELN (%) (L=4D)	CVN Impact	
			Temp.	Joules
760-850	510-610	30-40	-196°C	75

Manufactured by: GEE LIMITED

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