



DESCRIPTION

Basic coated electrode for nickel based 625 alloy

It is designed to match the composition and properties of 625 and used for welding of alloy 625, 825, 25-6MO, 9% Ni steels and a range of super austenitic stainless steels. This alloy is used for the high temperature strength and structural stability and is also used for its resistance to general corrosion, pitting, crevice and stress corrosion cracking in severe chloride media. Useful properties from -269°C to above 550°C are achieved. Used in petrochemical and power generation plants and also for overlays on pumps, valves and shafts in offshore and marine environments.

SPECIFICATIONS

ISO 14172	E Ni 6625	AWS A5.11	ENiCrMo-3
DIN	-	Werkstoff Number	-
Certifications	-	Shielding	-
Positions	PA, PB, PC, PD, PE, PF	Current	DC+

ASME QUALIFICATIONS

F-No (QW432)	43
A-No (QW442)	-

FERRITE

Ferrite	-
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PREN

PREN	52.19
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HARDNESS

Hardness	-
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CHEM. COMP. %

	DEFAULT
C	0.02
Mn	0.01
Ni	65
Cr	21.5
Nb	3.6
P	0.01
S	0.006
Mo	9.3
Si	0.4
Cu	0.005
Fe	0.5

MECHANICAL PROPERTIES

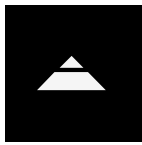
	MIN	VARIANT
Tensile strength R _m MPa	760	790
Yield strength R _{p0.2} MPa	420	430
Elongation A (L ₀ =5d ₀) %	22	30
Impact Charpy ISO-V	-	30J @ -196°C
Impact Charpy ISO-V	-	-

WELDING PARAMETERS

	2.5 mm	3.2 mm	4 mm	
Ampere	40A - 65A	70A - 100A	90A - 130A	120A -
Voltage	-	-	-	-
Packaging	60 pcs/kg	29 pcs/kg	19 pcs/kg	13 p
Packaging Type	Carton box and tube.	Carton box and tube.	Carton box and tube.	Carton box and



The information in this datasheet is the result of detailed research and is considered accurate as of the publication date. However, we cannot guarantee its complete accuracy, and it is subject to change without notice. Actual results may vary due to many factors like welding procedures, material composition, temperature conditions, bevel configuration, and specific manufacturing techniques. We accept no liability for any errors or omissions in this datasheet. For the most current information, please visit www.daikowelding.com.



625

DESCRIPTION

NICKEL ALLOYS

625

APPLICATION

Engineered to replicate the composition of alloy 625, this consumable is widely recognized for its exceptional resistance to general corrosion, pitting, crevice, and stress corrosion cracking, especially in challenging chloride environments. Elevated levels of Cr, Mo, and Nb contribute to its remarkable performance, endowing it with unparalleled strength that surpasses standard nickel-base alloys. With a broad operational range spanning from -269°C to above 1000°C , it is well-suited for welding heat-resistant alloys like Inconel 601, Incoloy 800/800H, or their combinations with other alloys, catering to various applications in furnace equipment, petrochemical plants, and power generation facilities. This consumable is versatile for performing overmatching corrosion-resistant welds in alloy 825, Hastelloys G and G3, alloy 28, 904L, and the 6%Mo superaustenitic stainless steel 2545Mo. Additionally, it is employed for overlays on pumps, valves, and shafts, particularly in demanding offshore and marine environments where high pitting resistance ($\text{PRE} = 50$) and tolerance to dilution are imperative. In welding high-strength ferrous alloys, including cryogenic 9% nickel steels, and for the reclamation of dies demanding rapid work-hardening and toughness, this consumable stands as a preferred choice. Notably, no preheat is required, and the maximum interpass temperature is set at 250°C . For superaustenitic alloys, the interpass temperature should be rigorously controlled, not exceeding 100°C .

ALLOY TYPE

Consumables matching the nickel base 625 alloy with typical composition of Ni-21%Cr-9%Mo-3.5%Nb.

MICROSTRUCTURE

In the as-welded condition this nickel base weld metal consists of solid-solution strengthened austenite with carbides.

MATERIALS

Also suitable to join 9%Ni steels.

EN W.Nr.: 2.4856.

ASTM: A494 CW-6MC, 904L.

UNS: N06625, S31254.

PROPRIETARY: Inconel® 625, 601 (Special Metals), Nicrofer 6020hMo, 6022hMo (VDM), 2545MO (Outokumpu), Incoloy® 800H, 825 (Special Metals).

