



DAIKOFCW 625P



NICKEL ALLOYS

625

DESCRIPTION

Rutile all position flux cored wire

Rutile flux cored wire for welding and cladding in all positions thanks to the fast-freezing slag. This wire rod is used for its high temperature strength and structural stability and 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. It is used for welding of alloy 625, alloy 825, alloy 25-6MO, 9% Ni steels and a range of high alloy austenitic and super austenitic stainless steels. Widely used in oil and gas production and processing.

SPECIFICATIONS

ISO 12153	T Ni 6625P M 21 2	AWS A5.34	ENiCrMo3Ti-4
DIN	-	Werkstoff Number	-
Certifications	-	Shielding	M21
Positions	PA, PB, PC, PD, PE, PF, PG	Current	DC+

ASME QUALIFICATIONS

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

FERRITE

Ferrite	-
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PREN

PREN	53.19
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HARDNESS

Hardness	-
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CHEM. COMP. %

CHEM. COMP. %	DEFAULT
C	0.03
Mn	0.3
Ni	62
Cr	22.5
Nb	3.7
P	0.002
S	0.002
Mo	9.3
Si	0.3
Cu	0.03
Fe	2
Ti	0.15

MECHANICAL PROPERTIES

MECHANICAL PROPERTIES	MIN	VARIANT
Tensile strength R_m MPa	-	750
Yield strength $R_{p0.2}$ MPa	-	470
Elongation A ($L_0=5d_0$) %	-	36
Impact Charpy ISO-V	-	50J @ -196°C
Impact Charpy ISO-V	-	-

WELDING PARAMETERS

WELDING PARAMETERS	1.2 mm	1.6 mm
Ampere	130A - 280A	200A - 350A
Voltage	22V - 30V	28V - 32V
Packaging	Ø 1,2÷1,6mm	Ø 1,2÷1,6mm
Packaging Type	BS300 spool	BS300 spool

V 01/2024



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).

