



DAIKOSTRIP 625

SAW - ESW

NICKEL ALLOYS

625

PRODUCT DESCRIPTION

Cladding strip 625 alloy.

Cladding for petrochemical industry, off-shore, valves, reactors, etc. Suitable for any application where high resistance to several kinds of corrosion agents is required.

SPECIFICATIONS

AWS A5.14	EQNiCrMo-3
EN ISO	-
DIN	-
Approvals	-
Shielding	DAIKOFLUX 940, 944, 942AS

ASME IX QUALIFICATION

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

FERRITE

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

PREN

F-No (QW432)	53
A-No (QW442)	-

HARDNESS

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

Typical Strip Composition (weight %)

C	Mn	Si	S	P	Cr	Ni	Mo	Cu	Fe	Al	Nb	Ti	Ta
0.01	0.03	0.1	<0.002	0.003	22	65	9.3	0.03	0.5	0.01	3.70	0.20	<0.03

TYPICAL SURFACE COMPOSITION AT 3.0MM

Base Material:	Type P1 according to ASME IX, thickness 40 mm
Process:	Electroslag double layer
Flux:	Daikoflux 940
Strip:	60x0.5 mm
Welding Parameters:	1400A; 24V; 20 cm/min.
Thickness of the deposit:	7.8 mm.
Deposit rate:	28 kg/h.

C	Mn	Si	Cr	Mo	Nb	Ti	Fe	Ni
0.020	0.15	0.20	21.50	8.2	3.3	0.07	4.2	Bal.