

KW-T625

For Inconel 625 / Incoloy 825

Classifications

EN ISO 18274:2005	: SNI6625 (NiCr22Mo9Nb)
AWS A5.14-2011	: ERNiCrMo-3
KS B 18274:2014	: SNI6625 (NiCr22Mo9Nb)
JIS Z 3334:2011	: SNI6625 (NiCr22Mo9Nb)

Approvals – I1 (100% Ar)

ABS	: ERNiCrMo-3
BV	: N90
DNV	: ER625
LR	: BF 9Nim
KR	: ERNiCrMo-3
NK	: KSWL91G (I)

Description

- TIG consumable for Inconel 625, Incoloy 825
- It can be used for surfacing of 9% Ni steels and dissimilar welding of Inconel 625 to stainless steel.
- The weld metal has high strength and good corrosion resistance at broad temperature

Polarity & shielding gas

- DCEN (DC-)
- Ar: 100% Ar (15 – 25 l/min)

Typical chemical composition of all-weld metal (%)

C	Si	Mn	Ni	Cr	Mo	Nb
0.01	0.08	0.03	63.80	22.24	8.67	3.36

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation	Impact Value (J)	
	(MPa)	(MPa)	(%)	-20 °C	-50 °C
AWS A5.9		Min. 760	Min. 15		
Example	640	800	32	220	200

Typical mechanical properties of all-weld metal

	Yield Strength	Tensile Strength	Elongation
	(MPa)	(MPa)	(%)
AWS A5.14		760	
Example	506	773	54