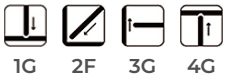
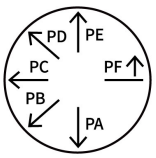
SR-625

Classification

AWS A5.11/ASME SFA-5.11 ENiCrMo-3
JIS Z 3224 DNiCrMo-3
EN ISO 14172 Ni 6625

Welding Positions





Features

- Good corrosion resistance to crevice and pitting, SCC
- Good Tensile Strength at high temperature
- Good Impact value at cryogenic temperature

Polarity

DC +, AC

Application Areas

- Inconel 60+ 625, steel and Nickel alloys Hardfacing of steel, 9% Nickel steel
- LNG storage tank manufactures and desulfurizations
- Heat exchanger Building of chemical carrier

Redrying Conditions

350~400□(662~752□) X 1hr

Approvals

ABS
✓

Typical Chemical Composition of All-Weld Metal (wt%)

C	Si	Mn	P	S	Ni	Cr	Mo	Nb	Fe
0.06	0.40	0.1	0.001	0.004	63.4	21.7	9.0	3.3	1.5

Typical Mechanical Properties of All-Weld Metal

Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
770(112)	36	-196(-320)	48(35)

Diameter / Welding Parameters / Packaging

Diameter mm(in)	Length mm(in)	F & HF	V-up, OH	Packaging
2.6 (3/32)	300 (12)	60~90	60~90	PVC - Packet 2.5kg(5.5lbs), Carton 10kg (22lbs)
3.2 (1/8)	350 (14)	70~110	70~110	
4.0 (5/32)	350 (14)	110~140	100~130	
5.0 (3/16)	350 (14)	120~150	110~140	