

# GETIG 625

## IDENTIFICATION

Getig 625, ERNiCrMo3

## CLASSIFICATION

AWS/SFA-5.14: ERNiCrMo3, BS 2901-90 NA43

## DESCRIPTION

Solid nickel-base wire to match "625" type alloys with widespread applications. The wire gives a strong tough corrosion and heat resistant deposit. The deposited welds are of X-Ray quality. Also suitable for welding Alloy 825 and for dissimilar joint welding involving Inconel alloy 625 and Incoloy 825 alloys, carbon steel low alloy steel and stainless steel.

## CHEMICAL ANALYSIS (RANGE) %

C	Mn	Si	Cr	Nb	Mo	S	P	Cu	Ti	Fe	Ni	Al
0.05 max	0.5 max	0.5 max	20 - 23	3.15 - 4.15	8-10	0.015 max	0.015 max	0.5 max	0.4 max	5.0 max	56 min	0.4 max

## TYPICAL APPLICATIONS

- Use for general purpose welding high nickel alloys for furnace parts for welding 6 % Mo super-austenitic stainless steels.
- Use for cladding overlays, pumps, valves joining faces in off-shore and marine environments.
- Suitable for welding 9 % nickel steels for cryogenic applications.

## CORROSION RESISTANCE

Very good resistance to general and intergranular corrosion. Maximum resistance to pitting corrosion crevice corrosion and stress corrosion cracking in chloride bearing environments.

## SCALING TEMPERATURE

The weld metal is resistant to oxidation in air upto 1150°C.

**WELDING CURRENT** : DC (-)

**SHIELDING GAS** : 99.99% Agron 6-12 l/mn.

## PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (kg)	Packing / Box (kg)
1.6	1000 / 500	5	5 x 4 = 20
2	1000 / 500	5	5 x 4 = 20
2.40 / 2.50	1000 / 500	5	5 x 4 = 20
3.15 / 3.20	1000 / 500	5	5 x 4 = 20