

GM 625

IDENTIFICATION

GM 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	Ni	Mo	S	P	Fe	Ti	Cu	Al
0.1 max	0.5 max	0.5 max	20 - 23	3.15 - 4.15	58 min	08-Oct	0.015 max	0.015 max	5 max	0.4 max	0.5 max	0.4 max

MECHANICAL PROPERTIES (RANGE)

TS (N/mm ²)	YS (N/mm ²)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
760 - 850	510 - 610	30 - 40	-196°C	50 - 90

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 join 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% Argon, 6-12 l/mn.

PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
0.8	12.5
1	12.5

1.2	12.5
1.6	12.5
