

A low hydrogen MMA electrode for the all positional welding of Ni steel series, alloys 625 and 825. It can also be used for welding 9% Ni steel and other different steels with working temperatures to -196°C .

The weld metal deposited is resistant to inter-granular corrosion, pitting and oxidation at high temperatures (max. 1200°C). Efficiency 100%.

Classification

AWS	A5.11: E NiCrMo-3
EN ISO	14172: E Ni 6625

Approvals

Grades

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.02	0.60	0.40	≤ 0.015	≤ 0.015	21	Rem	9	3.30	3	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm^2	Tensile Strength N/mm^2	Elongation A5 (%)	Impact Energy ISO - V (J) -196°C	Hardness
As Welded	≥ 420	≥ 760	≥ 30	≥ 50	-

Materials

2.4856; 2.4839

UNS N06625; UNS N08825

Storage and redrying

Keep dry and avoid condensation.

Re-dry at $300-350^{\circ}\text{C}$ for 2 hours, 5 times max

Current condition and welding position

DC +



Packaging data

Diameter (mm)	Length (mm)	Current (A)	Electrode average weight (g)	Weld metal weight per electrode (g)
2,5	300	50-70	18,5	11,1
3,2	350	75-95	36,0	21,6
4,0	350	100-130	51,8	32,1
5,0	350	140 - 170	90,0	43,0