

## MIG-MAG Wires Nickel and Copper alloys

Nifil 625 is a nickel alloy solid wire, for use in cryogenic welding and 9% Ni steel welding applications. Suitable for high temperature applications (1100°C). It is used for components which will undergo heat treatments. Good resistance to intercrystalline corrosion.

Classification	
AWS	A5.14: ER NiCrMo-3
EN	18274: Ni 6625

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.025	-	0.30	≤ 0.020	≤ 0.015	21	60	9	3.50	3	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) -196°C	Hardness
As Welded	≥ 440	≥ 760	≥ 35	≥ 55	-

Gas test: Acc. To EN 439: M12(Arcal12)

**Shielding Gas:** Acc. To EN 439: M12(Arcal12-Arcal121)

### Materials

2.4856; 2.4839

UNS N06625; UNS N08825

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** K300 Kg. 16

Diameters	0,8	1,0	1,2	1,6		