

TIG Rods Nickel and Copper alloys

Nirod 625 is a nickel alloy TIG rod, for use in cryogenic welding and the welding of 9% Ni steels. The good resistance to high temperatures makes Nirod 625 suitable for the welding of components which will undergo heat treatments. Good resistance to intercrystalline corrosion.

Classification

AWS A5.14: ER NiCrMo-3

Approvals

TÜV

Grades

see Appendix, Classification Society Approvals, for details pag. 521

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.10	-	0.30	≤ 0.020	≤ 0.015	21	60	9	3.50	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	≥ 440	≥ 760	≥ 35	≥ 55	-

Gas test: Acc. To EN 439: I1(Arcal1)

Shielding Gas: Acc. To EN 439: I1(Arcal1)

Materials

2.4856; 2.4839

UNS N06625; UNS N08825

Storage

Keep dry and avoid condensation

Current condition and welding position

DC-



Packaging data: Tube 5 kg

Diameters (L: 1000 mm)	1,2	1,6	2,0	2,4		
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Further forms of delivery on request.