

FLUXINOX 625

Cored Wires Stainless and Heat resistant steels

Fluxinox 625 is a rutile flux cored wire used for welding cryogenic steels and 9% Nickel steel, alloys 625 and 825. The weld metal deposited is resistant to intergranular corrosion, pitting and oxidation at high temperatures (max. 1200°C).

Classification
AWS similar to A5.11: ENiCrMo-3

Approvals	Grades

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

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	W	Cu
0.03	0.80	0.60	≤ 0.015	≤ 0.015	21	Rem	9	4	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	≥ 750	≥ 35	≥ 50	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal 21-Atal 6)

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	1,2					
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