

SW-625 Cored

Classification

AWS AWS A5.34/ ASME SFA-5.34 ENiCrMo3Ti-1/-4
JIS Z3335 TNi6625-FB1
EN ISO 12153 T Ni 6625 P M/C 2

Welding Positions



Features

- Excellent corrosion resistance of crevice and pitting, SCC
- Good Tensile strength in high temperature
- Good impact value at cryogenic temperature

Polarity

DC+

Application Areas

- Inconel 60+ 625, steel and Nickel alloys Hardfacing of steel, 9% Nickel steel
- LNG storage tank manufactures and desulfurizations
- Heat exchanger Building of chemical carrier

Shielding Gas

100% CO2
Ar+20~25% CO2

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Ni	Cr	Mo	Ti	Nb
100% CO2	0.01	0.4	0.1	0.004	0.002	66.5	20.5	9.0	0.2	3.35
Ar+20~25% CO2	0.01	0.4	0.1	0.004	0.002	66.0	20.8	9.2	0.2	3.32

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	725 (105)	41.6	-196 (-320)	65 (48)
Ar+20~25% CO2	730 (106)	42.0	-196 (-320)	72 (53)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	160~220	Spool 12.5kg(28lbs), 15kg (33lbs)

SWAW

GMW

GTAW

FCW

Metal-cored Wire

SAW Wire

SAW Flux