

SMT-625

Classification

AWS A5.14/ ASME SFA-5.14 ERNiCrMo-3
JIS Z 3334 SNi6625
EN ISO 18274 Ni 6625

Welding Positions



Features

- Good impact toughness at extra low temperature
- Dissimilar steels(B24Inconel 601, Incoloy800/800H or combination of these with other alloys)

Polarity

DC + (PULSE)

Application Areas

- LNG Storage Tank, equipment for gas desulfurization
- Petrochemical plants
- Heat exchangers
- 9% nickel steel

Shielding Gas

Ar, Ar + He

Approvals

ABS	BV	DNV	KR	LR	NK
✓	✓	✓	✓	✓	✓

Typical Chemical Composition of the Wire (wt%)

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	Ti	Nb	Al	Fe
0.03	0.08	0.03	0.01	0.001	0.03	63.9	22.7	9.1	0.21	3.55	0.09	0.3

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
Ar, Ar + He	770 (112)	45	-196 (-320)	150 (111)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)
1.2 (0.045), 1.6 (1/16)

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux