

# NIROD 625

## TOP FEATURES

- In sulphur-free atmospheres the weld metal is non-scaling <1200°C, in sulphurous atmospheres the weld metal can be used <500°C.
- Used for joining ferritic to austenitic steels (dissimilar) with operating temperatures or postweld heat treatment >300°C.
- Very resistant to stress corrosion cracking and pitting corrosion in a range of media including phosphoric acid, organic acids, sea water and polluting environments

## TYPICAL APPLICATIONS

- Cryogenic Applications
- Cladding
- Petrochemical
- Pipelaying
- LNG
- Dissimilar joints

## CLASSIFICATION

AWS A5.14 Er NiCrMo-3  
EN ISO 18274-A S Ni 6625 (NiCr22Mo9Nb)

## SHIELDING GASES (ACC. EN ISO 14175)

I1 Inert gas Ar (100%)

## CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, WIRE

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	Fe	Ti
0.025	0.4	0.3	≤0.020	≤0.015	21	Rest	9	3.5	0.3	0.3

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J)	
						+20°C	-196°C
Typical values	I1	AW	≥480	≥750	≥30	≥120	≥40

\* AW = As welded

## PACKAGING AND AVAILABLE SIZES

Diameter x Length (mm)	Packaging	Weight (kg)	Item number
1.6	PE Tube	5.0	W000283544
2.0	PE Tube	5.0	W000283545
2.4	PE Tube	5.0	W000283546

## TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to [www.lincolnelectric.eu](http://www.lincolnelectric.eu) for any updated information.