Supercore™ 625P

TOP FEATURES

- Smooth all position weldability
- Fully mechanized 3G welding
- Excellent slag removal
- Excellent weld bead profile

TYPICAL APPLICATIONS

- LNG storage tanks
- Petrochemical
- Welding of Ni-base alloys such as Alloy 625 and Alloy 825
- Welding of 6Mo super austenitic stainless steel
- Dissimilar welds between nickel alloys, stainless steels, and mild steel

CLASSIFICATION

AWS A5.34	ENiCrMo3T1-1/4
EN ISO 12153	T NI6625 P M21 2
	T Ni 6625 P C1 2

CURRENT TYPE

DC+ / AC

WELDING POSITIONS

All except vertical down

SHIELDING GASES (ACC. EN ISO 14175)

M21	Mixed gas Ar+ 15-25% CO_2
C1	Active gas 100% CO_2
Flow rate	15-25 l/min

APPROVALS

ABS	DNV
+	+

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

	C	Mn	Si	S	P	Cr	Ni	Mo	Nb	Cu	Ti	Fe
Typical	0.02	0.3	0.2	0.005	0.005	21	66	8.5	3.4	0.02	0.2	1.0

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Condition	0.2% Proof strength (MPa)	Tensile strength (MPa)	Elongation (%)		Reduction of area (%)	Impact ISO-V (J)		Lateral expansion (mm)	CTOD	Hardness, cap/mid
				4d	5d		+20°C	-196°C	-196°C	-170°C	(HV)
Required: AWS A5.34		420	690	25	22	-	-	-	-	-	-
Typical values	AW	500	780	45	43	42	95	85	1.40	0.51	230/230

AW = As welded

- = not specified

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S200)	5.0	SC625PMD-12
	SPOOL (S300)	15.0	SC625P-12

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 for any updated information.