selectarc Ni624

Nickel base Electrode
highly corrosion resistant

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Classification

AWS A5.11	:	ENiCrMo-12	EN/ISO 14172:	E-Ni6627
UNS	:	W86032		NiCr21Mo9Nb

Description & Applications

Basic coated electrode for welding of special austenitic stainless steels (6Mo-stainless steels and others) to themselves and to lower alloyed steels as well as for welding Nickel-Chromium-Molybdenum alloys.
Good weldability in all positions, except vertical down; stable arc, medium slag removal, regular weld beads. Due to its composition the weld metal is highly resistant to corrosion and presents a high yield and a high tensile strength.
Special applications are: Welding of Off-shore components, boilers, vessels, piping systems in the chemical and petrochemical industries as well as components of flue gas desulfurizing plants.

Base materials	UNS	Alloy	DIN	Material N°
	N06625	625	NiCr22Mo9Nb	2.4856
	N08825	825	NiCr21Mo	2.4858
	N08904	904L	X1NiCrMoCuN25 20 5	1.4539
	N08926	254SMo	X1NiCrMoCuN25 20 6	1.4529

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Nb	Fe	Mo	Cu	Ni
<0.03	0.4	0.8	21.5	2.1	3.0	9.2	0.1	base

All Weld Metal Mechanical Properties

$R_{p0,2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
470	760	40	+20°C >70

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350	5,0x450
Current	(A)	50-70	70-100	90-120	130-160

Rebaking : 1 h at 250-300°C. Joints to weld must be clean, exempt from grease, cracks .
Guide electrodes with a slight declination, weld with a short arc and prevent a high heat input by applying the stringer bead technique (weaving max. 2 times core wire diameter).
Nickel base alloys are welded without preheating and an interpass temperature <150°C.


1G/PA 2F/PB 2G/PC 3G/PF 4G/PE

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