# TIG NI625

*Old reference*: TIG Ni625

## Classification

ISO 18274 : S-Ni 6625 (NiCr22Mo9Nb) AWS A5.14 : ERNiCrMo-3

## Description & Applications

Solid rod for TIG welding of high nickel alloys as well as for special austenitic stainless steels. Used in the construction of equipment submitted to oxidizing and corrosive attacks. Excellent resistance to pitting, crevice and stress corrosion cracking in the presence of chlorides. Highly resistant at low temperatures, therefore also applied to weld 9% Ni steels.

## Typical Chemical Composition ( % )

| C | Si | Mn | Cr | Mo | Fe | Nb | P | S | Ni |
|---|---|---|---|---|---|---|---|---|---|
| 0.01 | 0.15 | 0.1 | 22.0 | 8.7 | 0.3 | 3.6 | <0.01 | <0.01 | Rem. |

## All Weld Metal Mechanical Properties

| $R_{p0.2}$ ( MPa ) | $R_m$ ( MPa ) | $A_5$ ( % ) | KV ( J ) |
|---|---|---|---|
| 520 | 790 | 40 | +20°C 160 |
| | | | -196°C 100 |

## Welding Current & Instructions

| Welding mode | Shielding Gas |
|---|---|
| TIG<br>= - | Ar : 6-12 l/min<br>Back shielding : Argon : 3-6 l/min |

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