



# CEWELD E NiCr 625 HLS

**TYPE** Nickel based high recovery electrode

**APPLICATIONS** CEWELD® E NiCr 625 HLS is developed for cladding Nickel-based alloys such as Alloy 625 or similar materials. This alloy can also be used for welding dissimilar nickel-based alloys to each other, to alloyed steels, to stainless steels and for joining 9% Nickel steels.

**PROPRIÉTÉS** Latest generation high recovery type (170%) guarantees optimum deposit rate and metallurgical quality and attractive welder appeal in the PA-PB position. Very good resistance against pitting corrosion and crevice corrosion. Very good against acid, neutral or alkaline media, with or without chlorides. Very good resistance at high temperatures, especially against oxidation.

**CLASSIFICATION**

AWS	A 5.11: E NiCrMo-3
EN ISO	14172: E Ni 6625 (NiCr22Mo9Nb)
W.Nr.	2.4831 / 2.4621
F-nr	43
FM	6

**CONVIENT POUR** **Ni 6625 / NiCr22Mo9Nb / 2.4831**  
**W.Nr:** 1.4529, 1.4539, 1.4547, 1.4876, 1.4958, 1.5656, 2.4660, 2.4816, 2.4856, 2.4858,

X1CrNiMoCuN20-18-7 - X10NiCrAlTi32-20 - X5NiCrAlTi31-20 - NiCr15Fe - NiCr22Mo9Nb - NiCr21Mo - X1NiCrMoCuN25 20 6 - X1NiCrMoCuN25 20 5 - NiCr21Mo - 8XNi9

**ASTM:** A 533 Gr1, B443, B444, B446

**UNS:** S31254 - N08800 - N08810 - N06600 - N06625 - N08825 - N08926 - N08020  
 Alloy 254SMO - Alloy 800 - Alloy 800H - Alloy 600 - Alloy 625 - Alloy 825 - Sanicro 28 - 6Mo

**AGRÉMENTS**

**POSITIONS DE SOUDAGE**



**ANALYSE CHIMIQUE  
TYPIQUE DU MÉTAL DE  
SOUDURE (%)**

C	Si	Mn	Cr	Ni	Mo	Fe	Nb+Ta	Nb
0.08	0.6	0.7	22	60	9	5	4	3.8

**PROPRIÉTÉS MÉCANIQUES**

Heat Treatment	R <sub>P0.2</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		Hardness
				RT	-196°C	
As Welded	455	795	37	78	60	HRC

**ETUVAGE** 300°C / 2 hr

**GAS ACC. EN ISO 14175**



# CEWELD E NiCro 625 HLS

E Nicro 625 HLS 2,5 X  
350MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418746

E Nicro 625 HLS 3,2 X  
350MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418753

E Nicro 625 HLS 4,0 X  
350MM

Packaging	KG/unit	EanCode
Can	2,27	8720663418760