Cromarod 625-170

SMAW - (Stick) - MMA

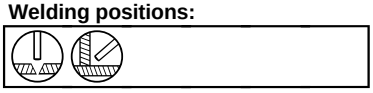
Stainless Steel

Date: 2007-10-19
Revision: 11

Description:
Cromarod 625-170 is a rutile-basic flux coated, high deposition nickel-base electrode of type Inconel 625 type, with 170% recovery. The weld metal provides very high resistance to pitting, crevice and stress corrosion and is suitable for a wide range of applications from -80 °C temperature up to +550 °C. Cromarod 625-170 runs with a stable arc to produce a smooth weld bead finish and easy slag detachability. It is practically suitable for high productivity fillet welding and surfacing applications.

Applications:
For welding of high alloyed austenitic steels and nickel base alloys.
Material no. 1.4529, 1.4539, 2.4618, 2.4619, 2.4856.
Welding of dissimilar joint combinations of mild and low alloy steels to stainless steels, especially where high temperature conditions prevail.

Welding positions:



Coating type:
Basic high recovery, 170%

Welding current:
DC +, AC 0CV > 39V

Ferrite content:
FN 0 (WRC-92)

Redrying temperature:
350 °C, 2h

Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min			0,3			20,0	56,0
Typical	0,04	0,6	0,7	0,01	0,01	21,0	bal
Max	0,10	0,75	1,0	0,020	0,015	23,0	

	Mo	Cu	Nb	Fe
Min	8,0		3,15	
Typical	9,0		3,4	2,0
Max	10,0	0,5	4,15	7,0

Mechanical properties

	Specified	Typical
Yield strength, Rp0.2%:	≥ 420 MPa	460 MPa
Tensile Strength, Rm:	≥ 700 MPa	730 MPa
Elongation, A5	≥ 25%	33%
Impact energy, CV:	20 °C • ≥ 40 J	20 °C • 45 J
	-80 °C • ≥ 32 J	-80 °C • 35 J

Classification:

EN ISO 14172	E Ni 6625
AWS A5.11	E NiCrMo-3

Approvals:
TÜV
CE

Note
Core wire:
P ≤ 0.005%
S ≤ 0.005%

Product data

Diam.mm	Length mm	Product code	Current A	Voltage V	Kg weld metal/kg electrodes	No. of electrodes/kg weld metal	Kg weld metal/hour arc time	Burn-off time/electrode (sec.)
2,5	350	74842500	80-120	23	0,67	42	1,1	73
3,2	350	74843200	120-160	23	0,70	26	1,5	78
4,0	350	74844000	180-220	23	0,73	18	2,3	79