

Technical data sheet

011121MBA

**Cored welding wire
GAMMA 625****CLASSIFICATION**

AWS A 5.34 - 2007: ENiCrMo3T0-4
 AWS A 5.34M - 2007: TNi6625-04
 EN ISO 12153: T Ni6625 (NiCr22Mo9Nb) B M21 3

DESCRIPTION

- Special flux cored nickel base wire for gas shielded arc welding
- Latest generation basic slag guarantees optimum metallurgical quality and attractive welder appeal
- Meets the NiCrMo-3 requirements
- Together with enhanced productivity, GAMMA 625 offers many other advantages compared to solid wires: improved weldability, almost no spatter, better arc stability, improved wetting properties, better bead appearance and shape, and use of classical M21 gas mixtures

APPLICATIONS

GAMMA 625 is suitable for welding and cladding nickel-based alloys such as alloy 625 or similar materials. It is also used for dissimilar welding of nickel-based alloys to each other, to alloyed steels or to stainless steels and for joining 6% molybdenum super austenitic steels or 9 % nickel steel.

Examples:

Alloy	UNS	EN Designation	Material Number
625	N06625	NiCr22Mo9Nb	2.4856
825	N08825	NiCr21Mo	2.4858
6% Mo super austenitics	N08028	X1 NiCrMoCu 31 27 4	1.4563
	N08031	X1 NiCrMoCu 32 28 7	1.4562
	N08926	X1 NiCrMoCuN 25 20 6	1.4529
9% Ni steel	K81340	X8Ni9	1.5662

APPROVALS

TÜV (11803.00)

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Mo	Nb	Fe	Ni
0.025	0.4	0.3	21	9	3.4	0.4	Bal.

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	As [%]	CVN [J]
760	420	27	-196°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2%[MPa]	As [%]	CVN[J]
780	500	40	-196°C: 70

SHIELDING GASEN ISO 14175: M21 (Ar + 15 - 25% CO₂)**OPERATING CONDITIONS**

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]	Gas flow [l/min]
1.2	DC+	130 - 250	24 - 32	12 - 25	10 - 20
1.6	DC+	150 - 300	24 - 32	12 - 25	10 - 20

WELDING POSITIONS

Flat, Horizontal

PACKAGING

Diameter	1.2 mm	1.6 mm
Spool type	EN ISO 544 – ASME IIC SFA-5.2 M: BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us

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