


Technical data sheet <small>011121MBA</small>	Cored welding wire GAMMA V 625	
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CLASSIFICATION

AWS A 5.34:	ENiCrMo3T1-4 / ENiCrMo3T1-1
AWS A 5.34M:	TNi6625-14 / TNi6625-11
EN ISO 12153:	T Ni6625(NiCr22Mo9Nb) P M21 1 / T Ni6625(NiCr22Mo9Nb) P C1 1

DESCRIPTION

- Flux cored nickel base wire for gas shielded arc welding
- Meets the NiCrMo-3 requirements
- Designed for all-position operability

APPLICATIONS

GAMMA V 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 (19334.00), DNV

TYPICAL ALL-WELD METAL ANALYSIS [%]

C	Mn	Si	Cr	Mo	Nb	Fe	Ni
0.020	0.02	0.4	22	8.8	3.4	<1.0	Bal.

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
690	420	27	-196°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
760	500	40	-196°C: 70

SHIELDING GAS

EN ISO 14175: M21 (Ar + 15% < CO₂ ≤ 25%) or CO₂

OPERATING CONDITIONS

Diameter [mm]	Current type	Amperage [A]	Voltage [V]	Stick-out [mm]	Gas flow [l/min]
1.2	DC+ / AC	130 - 220	24 - 32	12 - 25	10 - 20

WELDING POSITIONS

All positions

PACKAGING

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

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.