

## Nickel alloy Covered Electrodes

# KW-A625

For nickel alloy (Inconel 625)

### Classifications

EN ISO 14172:2004	: E Ni 6625	JIS Z 3224	: DNiCrMo-3
AWS A5.11-05	: ENiCrMo-3	KS D 7021	: DNiCrMo-3

### Description

- Covering is lime titania type for welding of Inconel 625, Incoloy 825 and other molybdenum containing stainless steels. The weld metal has high strength at room and elevated temperatures and has exceptional corrosion resistance, including resistance to pitting, crevice corrosion, etc.
- The electrodes provide excellent operability for groove and fillet welding in the downhand position.
- Easy slag removal, low spatter generation and stable arc characteristics.
- Redry the electrode at 250~350°C for 30~60 minutes prior to use.

### Welding positions



### Typical chemical composition of all-weld metal (%)

C	Si	Mn	P	S	Fe	Ni	Cr	Mo	Nb+Ta
0.03	0.22	0.54	0.008	0.004	1.64	Rem.	21.9	8.6	3.8

### Typical mechanical properties of all-weld metal

	Y.S (0.2%OS) (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.11		min. 760	min. 30	
EN ISO 14172	min. 420	min. 760	min. 27	
Example	520	770	40	AW

\* AW : As-Welded

### Sizes available and recommended currents (DC+)

Dia.	(mm)	2.6	3.2	4.0	5.0
Length	(mm)	300	350	350	350
Current (Amp.)	F	60~90	90~120	140~180	170~210
	V-OH	60~90	70~100	120~160	130~170

### Approvals

DNV

Remark : For NV 1.5Ni, NV 3.5Ni, NV 5Ni, and 9Ni. Test Temp. -196°C

\* Others : CE