

TALWELD 625

Classification

AWS A5.14 ERNiCrMo-3

Description

TALWELD 625 is a nickel-chromium-molybdenum GMAW wire for the welding of 9% nickel steel, 625, 601, 802, 825 and other nickel-base alloys. It also finds widespread use as a cladding material for high temperature or corrosive environments.

Application

Typical applications for TALWELD 625 include

- welding of nickel-chromium-molybdenum alloys to themselves, to steel and to other nickel base alloys
- cladding of steel with nickel chromium-molybdenum weld metal
- welding of the clad side of joints in steel with nickel-chromium-molybdenum alloy
- applications in the chemical process industry, in marine engineering and high-grade plant/engineering (primarily for the petro-chemical industry)
- applications where the operative temperature ranges from cryogenic to 540°C

Shielding Gas

Argon + 25-30% He

Chemical Composition of Solid Wire

Ni	Cr	Mo	Nb+Ta	Fe	Co	Si	Mn	Cu	C	P	S	Al	Ti
60%	20 -	8 -	3.15 -	5.0%	1.0%	0.5%	0.5%	0.5%	0.1%	0.015%	0.015%	0.3%	0.4%
Min.	23%	10%	4.15%	Max.	Max.	Max.	Max.	Max.	Max.	Max.	Max.	Max.	Max.

Typical Mechanical Properties of Weldmetal

Tensile strength	Yield strength	Elongation
760 MPa	465 MPa	36%

Packaging and Machine Settings – GMAW

Diam. (mm)	0.9	1.2
Spool (300mm)	15 kg	15 kg
Volts	25-28	28-32
Current, A	150-190	180-230

Wire Diam.	15 kg Spool
0.9mm	NMM62509
1.2mm	NMM62512

TALARC Pty Ltd
10-16 Syme St
Brunswick, Vic 3056
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710
W: www.talarc.com.au E: sales@talarc.com