



MIG 625



Standards

AWS A5.14
ERNiCrMo-3

EN ISO 18274
Ni 6625

W. Nr.
2.4831

Description & applications

Nickel-based filler metal in solid wire spools for MIG welding of high Nickel superalloys and super-stainless steels such as 904 L grade. The high levels of Cr, Mo et Ni alloying elements of Inconel 625 insure a very good corrosion and oxidation resistance in highly aggressive environments such as waste incinerators, off- shore oil & gas environments, desalination , etc...

Inconel 625 is frequently used for overlays, including on low alloy carbon steels;

Typical chemical composition (%)

C max	Mn	Si	Cr	Fe	Mo	Nb	S max	Ni
0.010	0.1	0.12	22.0	0.5	8.5	3.7	0.010	Base

Typical mechanical properties of all-weld metal

Rm	Rp 0,2	A5	KV-196°C
690 MPa	430 MPa	28 %	70 J

Operating parameters

Recommended shielding gas protection :

EN ISO 14175 M12 : Argon + 2-3%CO2 For overlay : Argon 30% + Helium 70%



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