

## **COROLOY<sup>®</sup> E 625**

### **CLASSIFICATION:**

DIN 1736	AWS A5.11	DIN EN ISO 14172
EL-NiCr 20 Mo 9 Nb	E NiCrMo-3	E Ni 6625 (NiCr22MoNb)

### **GENERAL CHARACTERISTICS:**

COROLOY E 625 is a nickel base electrode with a recovery of 140% and excellent weldability on AC even at low voltages. Suitable for joining and claddings, wherever characteristics of Alloy 625 are required. The austenitic deposit is insensitive to hot-cracking and free of embrittlement at high as well as at low temperatures, non-scaling up to 1000° C, and cold tough down to -269° C. No diffusion of carbon into the weld metal at elevated temperatures.

### **APPLICATION:**

Used for service-temperatures of more than 300° C in chemical industry, petrochemical industry, glassworks, civil engineering, repairing and maintenance workshops.

### **TYPICAL ALL WELD METAL ANALYSIS ( % ):**

C	Si	Mn	Cr	Ni	Mo	Nb	Fe
0,04	1,0	0,6	22	Bal.	9	3,5	< 6

### **TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:**

Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Yield strength R <sub>p0,2</sub> N/mm <sup>2</sup>	Elongation A <sub>5</sub> %	Impact strength J
750	500	35	- 196 C°; 40

### **CURRENT:**

= + / ~ 50 V

### **WELDING POSITIONS:**

PA, PB, PC, PD, PE, PF

### **REBAKING:**

1 h, 350 °C + / - 10 °C ( if required )