

# HANKOOK WELDTEK CO.,LTD

31, Myeongnyesandan 1-ro, Jangan-eup,  
Gijang-gun, Busan, Korea

TEL : 82-51-727-5588 FAX : 82-51-727-9160



## WT-625

AWS A5.34 ENiCrMo3T1-1/4

Inconel 625,  
Incoloy 825

### Applications

WT-625 is designed for welding of Inconel 600 + 625 and Nickel alloys, 9% Nickel steels.  
(LNG storage tank manufacture, desulfurization, Heat exchanger, Building of chemical carrier)

### Characteristics on Usage

- 1) It can be used for surfacing of 9% Ni steels or dissimilar welding of Inconel to stainless steels.
- 2) The weld metal has high strength at room and elevated temperatures and has exceptional corrosion resistance.

### Notes on Usage

- 1) Use 100% CO<sub>2</sub> gas or Ar+20~25% CO<sub>2</sub>.
- 2) The optimum flow of Ar+20~25% CO<sub>2</sub> gas for shielding is 20~25ℓ/min.

### Typical Chemical Composition of All-Weld Metal(%) (Shielding gas : MIX)

	chemical composition(%)									
	C	Mn	Si	P	S	Cr	Mo	Nb+Ta	Fe	Ni
AWS	≤0.10	≤0.50	≤0.50	≤0.02	≤0.015	20.0~23.0	8.0~10.0	3.15~4.15	5.0	≥58.0
WT-625	0.04	0.30	0.28	0.001	0.007	21.84	8.84	3.65	0.68	62.5

## Typical Mechanical Properties of All-Weld Metal (Shielding gas : MIX)

	Tensile strength (N/mm <sup>2</sup> )	Elongation %	Impact value (J) -196°C
AWS	≥ 690	25	-
WT-625	763	38	65

## Sizes Available and Recommended Currents ( DC + )

Dia. (mm)		1.2mm
Current (A)	F & HF	180 ~ 220
	V-up & OH	120 ~ 170

## Welding position



1G



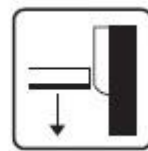
2F



3G



V-UP



V-DOWN



4G