



GB/T 13814 ENi 6625

AWS A5.11 ENiCrMo-3

EN ISO 14172- ENi 6625

AK ENiCrMo-3

Description: Nominal composition is 60%Ni-22%Cr-9%Mo-5%Fe-3.5%Nb+Ta. is Ni-Cr-Mo type of manual electrode; Due to the high alloy content, can be used in a wide range of temperature, from low temperature to 540C; Has high strength level and corrosion resistance under room and high temperature, which includes pitting resistance, crack corrosion resistance, and stress release corrosion resistance in sulfuric acid environment; Stable arc, beautiful weld bead appearance, few spatter, easy slag removal, excellent blowhole resistance. and stable deposited metal mechanical properties.

Application: Suitable for welding Ni-Cr-Mo series alloy. such as Inconel 601/ 625, ASTM B443. Alloy 20, incoloy 800, 800H, 825. can also be used for welding 9%Ni steel; Low hydrogen type manual electrode, can be used for cladding on steel surface. and dissimilar steel welding between steel and nickel alloy.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Fe	Ni	Cr	Mo
Requirement	0.10	0.80	2.00	0.015	0.02	7.00	≥ 55	20.0-23.0	8.0-10
Actual Result	0.017	0.35	0.5	0.006	0.009	5.00	60.2	21.00	8.5

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	≥760	≥420	27	50J(-196℃)
Actual Result	780	460	35	83