



# TIG 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 sticks for TIG 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
<b>0.010</b>	<b>0.1</b>	<b>0.12</b>	<b>22.0</b>	<b>0.5</b>	<b>8.5</b>	<b>3.7</b>	<b>0.010</b>	<b>Base</b>

## Typical mechanical properties of all-weld metal

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

## Operating parameters

Recommended shielding gas protection :

EN ISO 14175 I1 : 100 % Argon 6-12 l/mn      Root : Argon,Nitrogen 3-6 l/mn



**SADEV INOX – 2 Allée des Faisans – 74600 SEYNOD – France**

Tel: 04 50 33 70 75/ Fax 04 50 33 70 38 [info@sadevinox.com](mailto:info@sadevinox.com) [www.sadevinox.com](http://www.sadevinox.com)