


<b>NCM-625</b>	<b>A CHEMICALLY BASIC FLUX COATED MMA ELECTRODE          DEPOSITING A NICKEL BASED ALLOY          HIGH IN BOTH CHROMIUM AND MOLYBDENUM</b>			<b>DATA SHEET          NO.          90</b>									
SPECIFICATION	AWS A5.11	BS EN ISO 14172	JIS Z 3224										
CLASSIFICATION	ENiCrMo-3	E Ni 6625	DNiCrMo-3										
PRODUCT DESCRIPTION	<p>The chemically basic flux is extruded onto a high purity nickel chromium core wire. The flux contains the remaining alloying elements together with alloys for deoxidation and grain refinement.</p> <p>The blend of silicates used during electrode production ensure both coating strength and resistance to subsequent moisture absorption.</p>												
WELDING FEATURES OF THE ELECTRODE	<p>The electrode is suitable for use on both AC and DC+ and welds with great arc stability and thus control of the molten weld pool. Slag detachability is good.</p> <p>The weld beads are bright and evenly rippled with fillet welds slightly convex.</p> <p>Strike and re-strike should be made with the established back step technique.</p>												
APPLICATIONS AND MATERIALS TO BE WELDED	<p>Welding the following materials:          ASTM / ASME UNS N06625 A494 Cu 6Mo cast.</p> <p>Proprietary Alloys:          INCONEL 625 (Special Metals),          Nicrofer 6020hMo and 6022hMo (Krupp VDM).</p> <p>May also be used for superaustenitic alloys such as:          254SMo (Avesta), Sanicro 28 (Sandvick), Nicrofer 3127LC (Krupp VDM),          Incolloy 825 (Special Metals), Nicrofer 4221 (Krupp VDM),          904L (Uddelholm) and similar.</p> <p>Also for 9% Ni cryogenic steels and dissimilar welds.</p>												
WELD METAL ANALYSIS COMPOSITION % BY Wt.		C	Mn	Si	S	P	Cr	Ni	Mo	Nb	Fe	Cu	Co
WELD METAL PROPERTIES (ALL WELD METAL)	PROPERTY	UNITS	MINIMUM	TYPICAL	OTHERS								
WELDING AMPERAGE DCEP	Ø (mm)	2.6	3.2	4.0									
OTHER DATA	MIN	60	90	130					Electrodes that have become damp should be re-dried at 180 °C for 1 hour.				
RELATED PRODUCTS	MAX	100	130	180					Please contact our Technical Department for detail.				