

Classifications

EN ISO 18274	AWS A5.14 / SFA-5.14
S Ni 6625 (NiCr22Mo9Nb)	ERNiCrMo-3

Characteristics and typical fields of application

Thermanit 625 is a solid wire for submerged arc welding; high resistance to corrosive environment. Resistant to stress corrosion cracking. Resistant to scaling up to 1000 °C. Temperature limit: 500°C max. in sulphurous atmospheres. High temperature resistant up to 900 °C. Good toughness at subzero temperatures as low as -196 °C. For joining and surfacing work with matching / similar corrosion-resistant materials as well as with matching and similar heat resistant, high temperature resistant steels and alloys. For joining and surfacing work on cryogenic austenitic CrNi(N)-steels / cast steel grades and on cryogenic Ni-steels suitable for quenching and tempering.

Typical analysis of the wire

	C	Si	Mn	Cr	Ni	Mo	Nb	Fe
wt.-%	0.01	0.10	0.10	22.0	Bal.	9.0	3.6	< 1.0

Typical fluxes to combine

Process	Name	EN ISO 14174
SAW	Marathon 444	S A FB 2 AC
SAW	Marathon 504	S A BA 2 AC

Packaging

Size(s) in mm	Type	Weight
1,6	basket spool	25 kg
2,0	basket spool	25 kg
2,4	basket spool	25 kg
2,4	SAW drum™	300 kg

Other sizes and coil weights on request.

