

## Masterweld 625 (ERNiCrMo-3)

### Comparable specifications

**ASME SFA A 5.14:** ERNiCrMo-3  
**EN ISO 18274:** Ni 6625 - NiCr22Mo9Nb  
**BS 2901:** Pt 5 NA 43  
**Werkstoff Nr.:** 2.4831

### Description and applications\*

\* Illustrative, not-exhaustive list

This grade may be used for:

- welding of nickel-chromium-molybdenum alloys to themselves, to steel a/o to other nickel base alloys;
- cladding of steel with nickel chromium-molybdenum weld metal;
- welding of the clad side of joints in steel with nickel-chromium-molybdenum alloy;
- joining of other nickel alloys where micro-fissuring is problematic;
- applications in the chemical process industry, in marine engineering and within pollution control equipments;
- applications where the operative temperature ranges from cryogenic to 540°C;
- use in high-grade plant/engineering (primarily for the petro-chemical industry).

### Weldable base materials\*

\* Illustrative, not-exhaustive list

Inconel 601, Incoloy 800, Alloy 625, Alloy 825, Alloy 926

### All-weld metal mech. properties\*

\* For reference only values

**Tensile strength (Rm):**  $\geq 760 \text{ N/mm}^2$   
**Elongation:**  $\geq 35\%$

**Yield Strength (Rp<sub>0.2</sub>):**  $\geq 415 \text{ N/mm}^2$   
**Charpy-V Impact (R.T.):**  $\geq 100 \text{ J}$

### Chemical composition\*

\* For reference only values

C	Mn	Fe	P	S	Si	Cu	Ni	Co	Al	Ti	Cr	Nb+Ta	Mo
max	max	max	max	max	max	max	60.00	max	max	max	20.00	3.15	8.00
0.10	0.50	5.00	0.015	0.015	0.50	0.50	min	1.00	0.30	0.40	23.00	4.15	10.00

