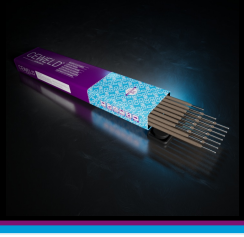

CEWELD E NiCro 825

certilas® THE FILLER METAL SPECIALIST

TYPE

Rutile-basic nickel based electrode for DC+ and AC current

APPLICATIONS

The excellent corrosion-resistant properties of Alloy 825 make the alloy a suitable choice for a variety of difficult applications. Uses include fabricated equipment found in chemical and petro-chemical processing, pulp and paper manufacturing, flue gas desulphurization systems and metal pickling operations.

PROPRIÉTÉS

Excellent weldability with fully austenitic weld metal with high resistance against stress corrosion cracking and pitting in media containing chloride ions. Good corrosion resistance against reducing acids due to the combination of Ni, Mo and Cu. Sufficient resistance against oxidizing acids. The weld metal is corrosion resistant in sea water.

CLASSIFICATION

AWS	A 5.4: ~E 383-16
EN ISO	14172: E Ni 8025 (NiCr29Fe30Mo)
W.Nr.	2.4652
F-nr	5
FM	6

CONVIENT POUR

E 27 31 4 Cu, E383, E Ni 8025
1.4500, 1.4529, 1.4539 (904L), 2.4858, 1.4563, 1.4465, 1.4577 (310Mo), 1.4133, 1.4500, 1.4503, 1.4505, 1.4506, 1.4531, 1.4536, 1.4585, 1.4586, 24858
G-X7NiCrMoCuNb 25 20, X1NiCrMoCuN25 20 6, X1NiCrMoCuN25 20 5, NiCr21Mo, X1NiCrMoCu 31 27 4,
N08926, N08904, ALLOY 825, N08028, UNS N08825

AGRÉMENTS

POSITIONS DE SOUDAGE

ANALYSE CHIMIQUE TYPIQUE DU MÉTAL DE SOUDURE (%)

C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Cu
0.02	0.5	2	25	40	5.5	0.2	25	2

PROPRIÉTÉS MÉCANIQUES

Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V -196°C	Hardness
As Welded	425	630	30	70	HRc

ETUVAGE

300°C / 2 hr

GAS ACC. EN ISO 14175