

Techalloy 625 FCA

DESCRIPTION

Gas shielded, all position flux cored wire that provides a final weld chemistry equivalent to the composition requirements of AWS A5.14 ERNiCrMo-3 solid wire. Used for dissimilar welding of Ni-Cr-Mo Alloys to Steel, surfacing of Carbon & Low Alloy Steels, joining of Ni-Cr-Mo alloys.

SPECIFICATIONS & APPROVALS

AWS A5.34 ENiCrMo3T1-4
 UNS W86625
 Werkstoff Nr. N/A

ASME SecN/A
 ASME QSC-395
 ISO TNi 6625-14

TYPICAL DEPOSIT CHEMISTRY

C	Mn	Si	Fe	Cr	Ni	Mo	Cb	S	P
0.03	0.40	0.30	3.1*	22.10	Bal.	9.10	3.70	0.001	0.010

* Low Iron version available Iron<1%

TYPICAL MECHANICAL PROPERTIES of WELD METAL

Tensile Strength	Yield Strength	Elongation	Impact @ 196°C	
109 Ksi	76Ksi	31%	44 ft-lbs	
786 Mpa	550 Mpa			

WELDING PARAMETERS

Process	Electrical	Voltage	Amperage	Shielding Gas	Extension	Welding Speed
FCAW	DCEP	25 - 26	.045" (1.14mm) 150-200	100% CO ₂	1/2"	290 - 400 IPM
		26 - 27	.062" (1.60mm) 200 - 250	75% Ar - 25% CO ₂	1/2"	190 - 275 IPM

