



Techalloy 625 FCA

Description:

Techalloy 625FCA is a 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 and Low Alloy Steels, joining of Ni-Cr-Mo alloys.

Specifications & Approvals:

AWS A5.34 ENiCrMo3T1-4 UNS W86625 CWB

Typical Chemical Composition

C	Mn	Si	Fe	Cr	Mo	Ni	Nb	W	S	P	Al	Ti	Cu
.04	.35	.30		21.5	9.0	BAL	3.5		.015	.020			

* Low Iron version available Iron < 1%.

Typical Mechanical Properties

Tensile Strength	110,000 PSI	786 MPA
Yield Strength	80,000 PSI	550 MPA
Elongation	30%	

Welding Parameters

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

Standard Packages:

MIG Wire– 33# wire basket		
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