SFC-625

AWS A5.34 ENiCrMo3T1-4
EN –
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FLUX CORED WIRES FOR NICKEL ALLOY STEEL

DESCRIPTION & APPLICATIONS :

- SFC-625 nickel-based flux cored wire with weld metal content 60%Ni-22%Cr-9%Mo-3%Fe-3.6%Nb.
- Suitable for Ni-Cr-Mo alloy steel, carbon steel and low alloy steel welding. Such as Inconel 625, Incoloy 825 and 9% Ni steel.

NOTE ON USAGE :

- Keep forward and back-forward weaving process and fill up the melting pool. Once bead appearance crack, use grinding method for repair (DO NOT use gouging carbon).

WELDING POSITION :

TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (Shielding Gas : 75%Ar+25%CO_2)

C	Mn	Si	P	S	Ni	Cr	Mo	Fe	Nb+Ta
0.030	0.30	0.35	0.0005	0.0005	64.50	20.80	8.70	0.3	3.5

TYPICAL MECHANICAL PROPERTIES OF WELD METAL : (Shielding Gas : 75%Ar+25%CO_2)

TENSILE STRENGTH $N/mm^2(Kgf/mm^2)$	ELONGATION RATE %	IMPACT VALUES -196°C J(Kgf-m)
720(73.5)	28	60(6.1)

SIZE AND RECOMMENDED CURRENT RANGE : DC(+)

Parameters \ Diameter (mm)	1.2mm	
	F & H	V & OH
Voltage (Volt)	23-30	22-28
Current (Amp)	130-250	120-200
Stickout (m/m)	15-25	
Flow Rate (l/min)	20-25	