

ES NiCrMo-3

Type Basic

SMAW

ENiCrMo-3

ESWECO
The Art of Welding

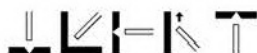
Description

ES NiCrMo-3 is a NiCrMoNb-based electrode for welding nickel alloys of the same or similar type, like Inconel 625, and for welding 5Ni and 9Ni steel. ES NiCrMo-3 is also suitable for welding UNS S31254 steel.

ES NiCrMo-3 electrode is utilized for welding piping systems and reactor components in the power generation industry and for high temperature service in an array of other engineering applications, including petrochemical plants and furnace equipment. ES ENiCrMo-3 is excellent for overlaying on steel where exceptional corrosion resistance is required, such as chloride contaminated cooling water in heat exchangers, as well as offshore and marine environments.

Current

DC+



Classifications

SFA/AWS A5.11	ENiCrMo-3
EN ISO 14172	E Ni 6625 (NiCr22Mo9Nb)

Typical all weld metal composition, %

C	Si	Mn	Cr	Ni	Mo	Nb	Fe	Cu	Al
0.03	0.4	0.2	21.7	63.0	9.3	3.3	2.0	<0.3	<0.4

Typical mech. Properties all weld metal

Yield stress, MPa	500
Tensile strength, MPa	780
Elongation, A5 %	42

Charpy V

Test temps, °C	Impact values, J
+20	70
-196	50

Welding parameters

Diameter, mm	Length, mm	Welding current, A	Arc voltage, V
2.5	300	50-80	23
3.2	350	70-110	25
4.0	350	100-140	27
5.0	350	120-170	24