

DAIKO 625

NICKEL ALLOY **DAIKO SF 625** **NICROS** MOST FAMOUS WIRE

THE HIGHEST PERFORMANCES OF OUR **DAIKO SF 625**, REACHED IN MANY YEARS OF EXPERIENCE ALL AROUND THE WORLD, ARE THE BEST GUARANTEES OF A TOP QUALITY PRODUCT!

WE ENSURE:

- ANALYSIS CONFORMING TO AWS A5.14 ER NiCrMo-3
- EVERY BATCH MADE WITH STRICTLY CONTROLLED CHEMICAL COMPOSITION
- FE CONTENT 0,5% MAX
- HIGH QUALITY WELDABILITY FOR ALL BATCHES

DAIKO 625 IS APPROVED BY THE BIGGEST WORLDWIDE USERS OF 625 ALLOYS, PARTICULARLY WHERE ROBOT WELDING SYSTEM APPLICATIONS ARE NEEDED

WELDING PERFORMANCES **DAIKO SF 625** ER NiCrMo-3

AVAILABLE IN: MIG - TIG - SAW

SPECIFICATIONS	BS 2901 Pt5 grade NA43	AWS A5.14 ER NiCrMo-3	DIN 1736 SG-NiCr21Mo9Nb (2.4831)
-----------------------	---------------------------	--------------------------	--

APPROVALS TÜV MIG - TIG

APPLICATIONS Welding of Alloys 625 at working temperature from -269°C to above 1000°C. Suitable for welding heat resisting alloys as Inconel 601 (except severe sulphidising conditions), Incoloy 800/800H or combinations of these with other alloys for power generation and petrochemical plants and furnace equipment. Also suitable for overmatching corrosion-resistant welds in Alloy 825, 6%Mo super-austenitic stainless 254SMo, Alloy 28, 904L, Hastelloy G and G3, and for overlays on valves, pumps and shafts, often in marine and offshore equipment where high pitting resistance (PRE=50) and tolerance to weld metal dilution is required. Welds in high strength ferrous alloys including cryogenic 9% Ni steels and for reclamation of dies when rapid toughness and work-hardening are needed.

TYPICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni	Mo	Nb+Ta	Cu	Al	Ti	Fe
0.02	0.02	0.10	0.005	0.005	22.0	65.0	9.0	3.50	0.05	0.20	0.20	<0.5

TYPICAL PROPERTIES "AS WELDED"

tensile strength	750 N/mm2
0,2% proof stress	500 N/mm2
elongation on 4D.	38%
impact energy	at -196°C = 80J
PRE	50
hardness "as welded"	250 HV
hard drawn hardness	450 HV

SHIELDING GAS TIG: pure argon with back protection
MIG: pure argon or mixture Ar + 25-50% He

COMPLEMENTARY PRODUCTS Covered electrodes
TECH-ROD 112 AWS A5.11 E NiCrMo-3 Approvals
TECH-ROD 112LFe AWS A5.11: 2010 E NiCrMo-3 CWB-ABS-FBTS
G-TECH 112 AWS A5.11 E NiCrMo-3 CWB

Flux cored wire
DAIKO FCW 625 AWS A5.34 ENiCrMo3T1-4

Strip
DAIKO STRIP 625 AWS A5.11 EQ NiCrMo-3

Electroslag high speed flux
DAIKO FLUX EHS 625 - basicity index 4.0

PACKAGING

MIG	K300	RANGE Ø 0,80 ÷ 1,60 mm	Kg 15 - 18
SAW	K415	RANGE Ø 2,00 ÷ 4,00 mm	Kg 25
ROD	CARTON BOX	RANGE Ø 1,20 ÷ 4,00 mm	Kg 5 - 10
TOURET	DIN760	RANGE Ø 1,00 ÷ 2,40 mm	Kg 150 - 250
DRUM		RANGE Ø 1,20 ÷ 1,60 mm	Kg 150 - 200

OTHER PACKAGING AVAILABLE UPON REQUEST

**YEAH...
MIG DAIKO 625
RUNS FAST!**



LUCA BADOER - Ferrari Test Driver - DAIKO testimonial