

# DW-N625

80%Ar - 20%CO<sub>2</sub> EN ISO 12153 T Ni 6625 P M21 2 AWS A5.34 ENICrMo3T1-4 EN 2.4831

KOBELCO

## **Description and Application**

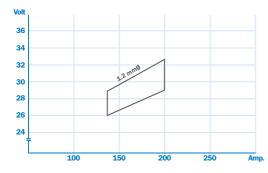
DW-N625 is a nickel based flux cored wire for welding nickel based alloys 625, 825 and also super austenitic stainless steels.

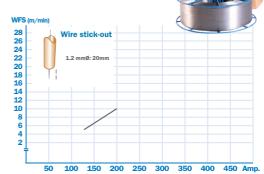
DW-N625 has a stable arc with minimal spatter, which makes it also an excellent product for welding in all positions.

This wire is recommended for a wide variety of applications, including overlay welding of carbon steel or low alloy steels and a wide variety of dissimilar metal joints.

Please note that for circumferential joining of pipes in fixed positions, DW-N625P is a better choice than DW-N625.

#### **Recommended Parameter Range, for flat position**





#### Typical Chemical Analysis (wt. %)

C	Si	Mn	P	S	Cu	Ni	Cr	Мо	Fe	Nb+Ta	Ti	Co	W	V
0.031	0.46	0.31	0.004	0.001	0.01	63.5	22.4	8.3	0.7	3.6	0.14	-	-	-

#### **Typical Mechanical Properties**

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	CV(J)0°C	CV(J)-196°C
	501	781	45	61	54
Guaranty	min 420	min 690	min 25		

### **Welding Positions**



#### **Approvals**

LR	DNV GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	-