

ASME II C SFA 5.14 : EQ NiCrMo 3  
 EN ISO 18274 : B Ni 6625  
 DIN 1736 : UP NiCr21Mo9Nb  
 W-Nr. : 2.4831

## DESCRIPTION

- Soudotape 625 is a strip designed for the single & multi layer strip cladding of alloy 625.
- Electroslag strip cladding is performable either in one or two layers depending of flux type, with Submerged arc strip cladding the full 625 chemical analysis is only achievable in two layers.

## SUITABLE FOR

- Reactors and vessels for chemical, steelmaking and nuclear applications.

## TYPICAL STRIP ANALYSIS

C	Mn	Si	Cr	Cu	Mo	Nb	Fe	Ni
0.015	0.1	0.1	22.0	0.07	9.0	3.6	0.3	Bal.

## TYPICAL WELD METAL ANALYSIS OF STRIP/FLUX COMBINATION (WEIGHT%)

- Submerged arc strip cladding with RECORD NFT 201 on a 0.2% C - Steel

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	Thickn (mm)
2 <sup>nd</sup> Layer (Alloy 625)	NFT 201	0.02	1.0	0.3	20.5	Bal.	8.5	2.9	3.0	4.2

- Electroslag strip cladding with RECORD EST 201 / EST 237 / EST 625-1 / EST 236 on a 0.2% C Steel

	Flux RECORD	C	Mn	Si	Cr	Ni	Mo	Nb	Fe	Thickn. (mm)
2 <sup>nd</sup> Layer (Alloy 625)	EST 201	0.02	0.1	0.3	21.5	Bal.	8.8	3.3	2.5	4.2
1 <sup>st</sup> Layer (Alloy 625)	EST 237	0.03	0.1	0.2	21.3	Bal.	8.2	3.2	9.4	4.3
1 <sup>st</sup> Layer (Alloy 625)	EST 625-1	0.025	0.2	0.3	21.5	Bal.	9.0	3.5	7.9	5
2 <sup>nd</sup> Layer (Alloy 625)	EST 236	0.025	0.1	0.3	21.0	Bal.	8.7	3.2	5.0	3
2 <sup>nd</sup> Layer (Alloy 625)	EST 229	0.1	0.3	0.27	21.5	Bal.	8.36	3.2	4.3	4

## APPROVALS

Flux RECORD	TÜV
EST 236	09336.00
NFT 201	09406.00

## AVAILABLE STRIP SIZES

- Standard : 30 x 0.5 mm, 60 x 0.5 mm or 90 x 0.5 mm.
- Other sizes on request.

## PACKING

- 30 x 0.5 mm : 25 kg to 30 kg.
- 60 x 0.5 mm : 50 kg to 60 kg.
- 90 x 0.5 mm : 70 kg to 90 kg.
- Other sizes on request.

**Note** : For additional information about cladding conditions and deposited weld metal properties, please refer to the corresponding flux technical data sheet, cladding data sheet or contact us.