

Standards:

EN ISO 14172	E Ni 6625 (NiCr22Mo9Nb)
EN 14700:	E Ni 2
AWS A 5.11:	E NiCrMo 3
Mat.-No.:	2.4621

capilla® 625 K**Product description:**

High corrosion resistance in several media, also against stress corrosion cracking.
Scale resistant at service temperatures up to 1100°C, good mechanical properties up to 1000°C and down to -196°C.

Max. service temperature in sulphurous media:
500°C.

Applications:

Joints and claddings of similar materials and steels.

Fusion welding of CrNi(N) steels for cryogenic applications and heat treatable nickel steels.

Appropriate base metals:

Alloy 800, 1.4876, 2.4856, 1.4539.

Typical weld metal composition:

[wt. - %]

	C	Cr	Mo	Nb	Ni
Min.		19	8	2	
Max.	0,6	30	11	4	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Tensile strength R_m :	760	[MPa]
Yield strength $R_{p0,2}$:	450	[MPa]
Yield strength $R_{p1,0}$:	-	[MPa]
Elongation (L=5d):	30	[%]
Impact strength (ISO-V):	75 60	[J] [J] -196°C

Positions: all except PG

Redrying: 320°C/2h

Dimension:

Ø [mm]	Length [mm]	Welding current [A]	Polarity
2,5	300	60 – 90	=(+)
3,25	350	80 – 110	
4,0	350	100 – 150	
5,0	350	150 – 200	

also available:
find in table of content

Capilla 625
Capilla 625 MIG

Capilla 625 WIG