

Standards:		capilla® 625
EN14700:	E Ni 2-200-ckptz	
(DIN 8555):	E 23-UM-250 CKPTZ	
EN ISO 14172:	E Ni 6625 (NiCr22Mo9Nb)	
AWS A5.11:	E NiCrMo 3	
Mat.-No.:	2.4621	
Recovery:	170%	

Product description:	Applications:
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.	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	Fe	Ni
Min.		19	8	2	2,5	
Max.	0,06	21	11	4	3,5	Bal.

Mechanical properties:

(without heat treatment; minimum values at ambient temperature)

Hardness:	220	[HB]
	400	[MPa]

Positions: PA, PB

Redrying: 320°C/2h

Dimension:	Ø [mm]	Length [mm]	Welding current [A]	Polarity
	2,5	350	60 – 90	= (+) ~
	3,25	350	80 – 110	
	4,0	350	100 – 150	
	5,0	450	150 – 200	

also available:
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Capilla 625 K
Capilla 625 MIG

Capilla 625 WIG