

EF-600N×KW-M625

For nickel alloy

Classifications

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|----------------------------------|-------------------------------|
| • Sub-arc flux | • SAW solid wire |
| EN ISO 14174 - 2012 : SA AF 2 DC | EN ISO 18274-2005 : S Ni 6625 |
| | AWS A5.14 - 2015 : ERNiCrMo-3 |

Description

- Agglomerated basic welding flux for Inconel 625 and dissimilar welding of low-alloyed steels and Nickel-alloyed steels.
- Excellent impact value at low temperature down to -196°C
- The weld metals show good mechanical properties and corrosion resistance.
- Excellent weldability such as stable arc and easy slag removal
- Redry the flux at 250~350°C for 60 minutes before use
- Add new flux periodically when continuously reusing the flux
- Excessive flux height may bring out poor bead appearance

Typical chemical composition of all-weld metal (%)

Wire	C	Si	Mn	Cr	Ni	Mo	Nb
KW-M625	0.02	0.2	0.2	22.0	Rem	8.3	3.3

Typical mechanical properties of all-weld metal

Wire	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J) -196°C	Remarks
KW-M625	560	820	42	85	AW

* AW : As-Welded

Packages

• Wire

Dia. (mm)	Type	Weight (kg)
2.0	Coil	25
2.4	Coil	25
3.2	Coil	25

• Flux

Mesh size	Type	Weight (kg)
12x60	Can	20