



ER NiCrMo-3 (ALLOY 625)

Nickel Alloy WIRE/GMAW



Standards

EN/ISO-Standard - 18274

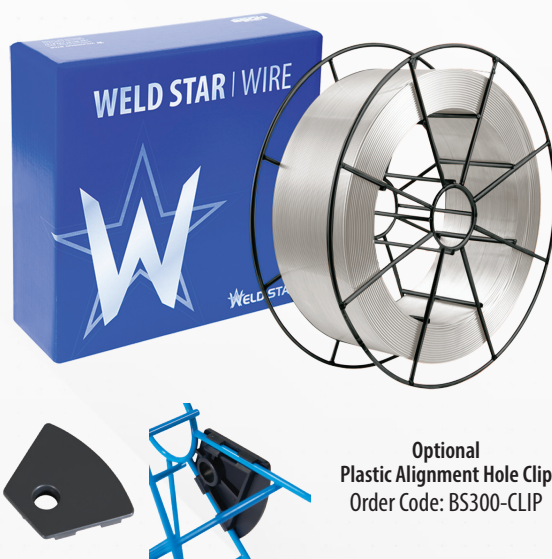
EN/ISO-Classification - S Ni 6625 - NiCr22Mo9Nb

AWS-Standard - A5.14

AWS-Classification - ER NiCrMo-3

Features and Applications

- High nickel alloy wire developed for welding and cladding nickel-based alloys such as 625 or similar material.
- Solid drawn in a very special way to obtain cleaner and higher quality welds with a bright seam and excellent ductility.
- The weld metal has very good mechanical properties at high and low temperatures.
- Good resistance to pitting and stress corrosion.
- Recommended working temperature ranges from cryogenic to 540°C.
- Precision layer wound for superior wire feeding characteristics.
- Typically used in the chemical process industry, marine engineering, nuclear reactor components, aerospace and within pollution control equipment etc.
- **Test Certificates can be found online @wilkinsonstar247.com**



Optional
Plastic Alignment Hole Clip
Order Code: BS300-CLIP

Typical Base Materials

Inconel 601, Incoloy 800, Alloy 625, Alloy 825, Alloy 926*

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF

Shielding Gases

EN ISO 14175 - I1, I3

Polarity

DC (+)

Chemical Composition % (Range)

C %	Mn %	Fe %	P %	S %	Si %	Cu %	Ni %	Co %	Al %	Ti %	Cr %	Nb + Ta %	Mo %
max	max	max	max	max	max	max	60.00	max	max	max	20.00	3.15	8.00
0.10	0.50	0.50	0.015	0.015	0.50	0.50	min	1.0	0.40	0.40	23.00	4.15	10.00

Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
6031100099	1.00	15	BS300 PLW	72
6031100298	1.20	15	BS300 PLW	72

Drums also available

Mechanical Properties

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)
≥760	≥415	≥35	≥100

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.