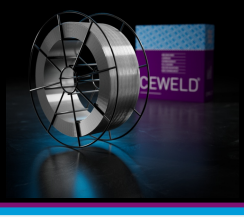


CEWELD Alloy 825

certilas® THE FILLER METAL SPECIALIST

TYPE

Solid Nickel based welding wire for gas shielded arc welding

APPLICATIONS

The excellent corrosion-resistant properties of CEWELD Alloy 825 make the alloy a suitable choice for a variety of difficult applications. Uses include fabricated equipment found in chemical and petro- chemical processing, pulp and paper manufacturing, flue gas desulphurization systems and metal pickling operations.

PROPRIÉTÉS

Excelent weldabillity with fully austenitic weld metal with high resistance against stress corrosion cracking and pitting in media containing chloride ions. Good corrosion resistance against reducing acids due to the combination of Ni, Mo and Cu. Sufficient resistance against oxidizing acids. The weld metal is corrosion resistant in sea water.

CLASSIFICATION

AWS	A 5.14: ERNiFeCr-1
EN ISO	18274: S Ni 8065(NiFe30Cr21Mo3)
W.Nr.	2.4858
F-nr	43
FM	6

CONVIENT POUR

G-X7NiCrMoCuNb25-20, X1NiCrMoCuN25-20-6, X1NiCrMoCuN25-20-5, NiCr21Mo, X1NiCrMoCu31-27-4,
N08926, N08904, N08028, N08825 ALLOY 825
1.4500, 1.4529, 1.4539 (904L), 2.4858, 1.4563, 1.4465, 1.4577 (310Mo), 1.4133, 1.4500, 1.4503, 1.4505, 1.4506, 1.4531, 1.4536, 1.4585, 1.4586

AGRÉMENTS

POSITIONS DE SOUDAGE

TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Cr	Ni	Mo	Ti	Fe	Cu	Al
0.05	0.3	0.8	22	42	3	1	30	2	0.1

PROPRIÉTÉS MÉCANIQUES

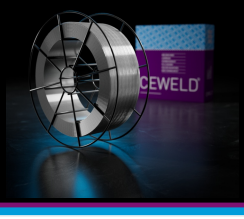
Heat Treatment	$R_{P0,2}$ (MPa)	Rm (MPa)	A5 (%)	Impact Energy (J) ISO-V -196°C	Hardness
As Welded	425	630	30	70	HRc

ETUVAGE

Not required

GAS ACC. EN ISO 14175

I1



CEWELD Alloy 825

ALLOY 825 1,2MM

Packaging	KG/unit	EanCode
BS-300	13,6	8720663419064
BS-300	13,6	8720663419606