

Nickel Base Alloy MIG•TIG Wire/Rod

GTN625 / GMN625

AWS A5.14 ERNiCrMo-3
ISO 18274-S Ni 6625
JIS Z 3334 S Ni6625

Product Features:

- Mo, Nb element contained in weld metal to get good heat and corrosion resistance, good mechanical properties.

Applications:

- Welding of similar grade of nickel base alloy.
- Welding of 9% Ni steel.
- Welding overlay to carbon, low alloy steel, stainless and Ni steels.

Shielding gas:

- Ar + 0.5~2.0%O₂ (GMAW)
- 100% Ar (GTAW)

Typical chemical composition of wire / rod (wt%)

C	Si	Mn	Ni	Cr	Nb	Mo	Fe
0.01	0.05	0.02	64.6	22.11	3.68	8.73	0.32

Typical mechanical properties of all weld metal

Tensile Strength N/mm ²	Elongation %
788	38

MIG Size (mm) & recommended welding parameters (A)

Diameter	0.9/1.0	1.2	1.6
Current range	70~180	100~230	180~280

TIG rod size diameter/length

Diameter (mm)	1.6	2.0	2.4	3.2
Length (mm)	1000	1000	1000	1000

Note:

Recommend pulse or spray arc (low current) for RT examination purpose.

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