



# WB625M MIG WELDING WIRE

**Classifications** AWS A5.14 : ERNiCrMo-3 BS2901 Part 5 : Grade NA43

**Product Description** WB625M is MIG wire for the welding nickel base alloys, overlaying carbon steels and combinations of the both.

**Applications** WB625M is extensively used in the offshore / marine industry. Excellent pitting resistance (PRE=50).  
 Typical materials to be welded:-  
 Alloy 625 : ASTM UNS N06625, BS NA21, DIN 2.4856, Inconel® 625 (Inco), Nicrofer 6020hMo, 6022Hmo(VDM), High Nickel : Inconel ® 601, Incoloy ® 800H, 825 (Inco) and equivalents, Super Austenitic : UNS S31254, (254SMO), 904L and similar alloys.  
 In addition to the above materials, WB625M is extensively used for overlaying carbon steels and combinations of the above. Suitable for welding and repairing of various grades of stainless steels and dissimilar combinations.

All-Weld Metal Composition (Weight %)		C	Mn	Ni	Si	S	P	Nb	Fe	Mo	Cu
min.		-	-	60	-	-	-	3.15	-	8.0	-
max.		0.05	0.50	-	0.50	0.015	0.015	4.15	1.0	10.0	0.20
		Al	Ti	Co	Cr						
min.		-	-	-	20						
max.		0.40	0.40	0.1	22						

Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength	N/mm <sup>2</sup>	760 min.
	Yield Stress/0.2% Proof Stress	N/mm <sup>2</sup>	400 min.
	Elongation on 4D	%	30 min.
	Impact Energy CV @ -196°C as-welded	Joules	70 min.

Wire Dia (mm)		0.6mm	0.8mm	1.0mm	1.14mm	1.6mm	2.4mm	3.2mm
min.		-	60	75	130	-	-	-
Current Range (Amps)	max.	-	170	200	250	-	-	-
min.		-	18	18	18	-	-	-
Volt Range (Volts)	max.	-	26	28	28	-	-	-

Packaging Information							
Kg Per Reel	-	13.6	13.6	13.6	-	-	-

**Storage**  
 It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 18°C, and a maximum relative humidity of 60%.

**Gas**  
 100% Argon or 98% Argon / 1% Oxygen

**Flow Rate**  
 12-16 l/min

## Current Conditions DC+ and Welding Positions

