



WB6625-P FLUX CORED WELDING WIRE

Classifications	BS EN ISO 12153: T Ni6625 P M 2 AWS A5.34: ENiCrMo3T1-1/4									
Product Description	All positional, rutile, Nickel base, formed, flux cored, welding wire. WB6625-P yields a "625 Alloy" deposit on clad applications.									
Applications	WB6625-P is used mainly for welding Nickel-Molybdenum-Chromium alloys, clad of carbon steel components and joining steels such as 9%Ni steels for LNG tanks and Nickel based alloys. Used for welding Nickel-Molybdenum-Chromium alloys to themselves and to C-Mn steel									
Wire Composition(Weight %)	C	Mn	Si	S	P	Cr	Ni	Mo	Nb	Fe
min.	0.02	0.01	0.20	-	-	20.0	Bal.	8.0	3.15	-
max.	0.04	0.04	0.50	0.010	0.020	23.0	-	10.0	4.15	3.0
Typical All-Weld Metal Mechanical Properties	Ultimate Tensile Strength					N/mm ²	760			
	Yield Stress/0.2% Proof Stress					N/mm ²	480			
	Elongation on 4D					%	45			
	Impact Energy CV @ -196°C					Joules	72			
	As welded									

Wire Dia (mm)		0.6mm	0.8mm	0.9mm	1.2mm	1.6mm	2.4mm	3.2mm
Current Range (Amps)	min.	-	-	-	150	-	-	-
	max.	-	-	-	260	-	-	-
Volt Range (Volts)	min.	-	-	-	21	-	-	-
	max.	-	-	-	26	-	-	-
Packaging Information								
Kg Per Reel		-	-	-	15.0	-	-	-
Storage	Storage It is recommended that the WB range of wires are stored in a dry heated store at a minimum temperature of 16°C, and a maximum relative humidity of 65%.							
Gases	Gas 75-80% Argon, 20- 25% CO ₂ mixture. Flow Rate 12-16 l/min							

Current Conditions DC+ and Welding Positions

