

DESCRIPTION

Executive 625 is a nickel-chromium-molybdenum alloy designed for welding alloy 625 and alloy 825 using TIG, MIG and SAW welding processes. This alloy is also used for many dissimilar Inconel® alloy joints and weld overlay. The high alloy content of Executive 625 produces high strength weld material with excellent corrosion resistance at elevated service temperatures. The increased level of molybdenum offers excellent resistance to stress corrosion cracking, pitting, and crevice corrosion. The low iron content of Executive 625 also makes it an excellent choice for overlay applications and has an operating range from cryogenic to beyond 1000°F (540°C).

Executive 625 filler metal is produced using high quality raw materials and tightly controlled chemistry to provide top quality, exceptionally clean wires that deliver the results fabricators demand. Use Executive 60/22/9 where flux cored wire is suited to the application.

APPLICATIONS & FEATURES

Executive 625 is a versatile filler metal that is used to weld dissimilar joints between nickel-chrome-molybdenum alloys and stainless, carbon or low alloy steels. It is also used when welding various nickel alloys such as 9% nickel steel, Monel®, Inconel®, 254SMO, and AL-6XN.

Executive 625 is used extensively for overlay applications as well due to its restricted low iron content which ensures the highest corrosion standard for these applications.

TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Mn	Fe	P	S	Si	Cu	Ni	Al	Ti	Cr	Nb+Ta	Mo Co
0.01	0.003	0.28	0.004	0.001	0.05	0.01	64.4	0.15	0.21	22.60	3.462	8.73.01

Tensile Strength: 110,000 PSI **Yield Strength:** 85,000 PSI **Elongation:** 34%

TYPICAL WELDING PARAMETERS

Process	Diameter	Voltage	Amperage	Gas Flow	Shielding Gas / Flux
GMAW - Short	.035"	17-20	70-90	30 to 50 CFH	100% Ar
	.045"	19-22	75-160		75% Ar / 25% He
	- Spray	.045"	30-32		190-250
- Pulse	.045"	18-20	120-150		
GTAW	.093"	Direct Current; Electrode -		30 to 40 CFH	100% Ar
SAW	.062"	28-32	250-280		NiCr-W Flux
	.093"	28-33	275-350		
	.125"	29-34	350-450		

STANDARD PACKAGING

GMAW (MIG)	33-lb wire baskets	500-lb Drum
GTAW (TIG)	10-lb plastic tube	40-lb box
SAW	60-lb wire coil	
	60-lb Acro Pak	



CLASSIFICATION

AWS/SFA 5.14, Class **ERNiCrMo-3**

Certified by the Canadian Welding Bureau (CWB) to AWS A5.14.