Stanvac INTERNATIONAL

Product Data Sheet

STAVINOX NiCrMo-3

Classification: **AWS A5.11 :** E NiCrMo-3 **EN ISO 14172 :** E Ni 6625 (NiCr 22 Mo 9 Nb)

Mat. No. : 2.4621

Description and Applications:

Nickel-base electrode for joint welding and plating on the same nickel-chromium-molybdenum and similar nickel-chromium steels, (heat-resistant) Cr and CrNi (Mo, N) steels and nickel-alloyed cold-tough pressure tank steels. Usable at working temperatures between -196°C and 1000°C (In case of sulphurous atmosphere only up to 500°C).

The fully austenitic weld metal is chemically stable, cold-tough, heat-resistant, scale-resistant up to 1000°C and resistant against embrittlement. High resistance against corrosive media.

Materials:

Mat No.	Steel
1.4529	X 1 NiCrMoCuN 25-20-7
1.4876	X 10 NiCrAlTi 32-21
2.4816	NiCr 15 Fe
2.4856	NiCr 22 Mo 9 Nb
2.4858	NiCr 21 Mo

Mat No.	Steel
-	Alloy 600
-	Alloy 800
-	Alloy 800
-	Alloy 825

Weld Metal composition (Typical Weight %):

C	Mn	Si	Cr	Mo	Nb	P	S	Fe	Ni	*Structure*
0.04	0.40	0.25	22.0	9.0	3.5	≤0.015	≤0.015	2.50	Rem.	*Austenite*

All weld metal Mechanical properties

Yield strength R_p 0,2 %N/mm^2	Tensile strength R_m N/mm^2	Elongation A_5 %	Charpy Impact value	
			ISO-V J RT	-196°C
> 420	>760	> 30	90	47

Welding recommendations:

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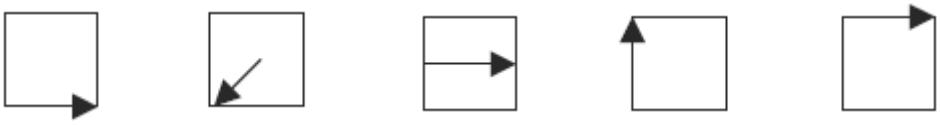
Re-drying: 250-300°C /2h

Pre-heating depends on base material

Welding positions:



Welding current

Dia./ Length (mm)	Amperage (a)
2.50/300	50-70
3.20/350	80-100
4.00/350	100-140

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